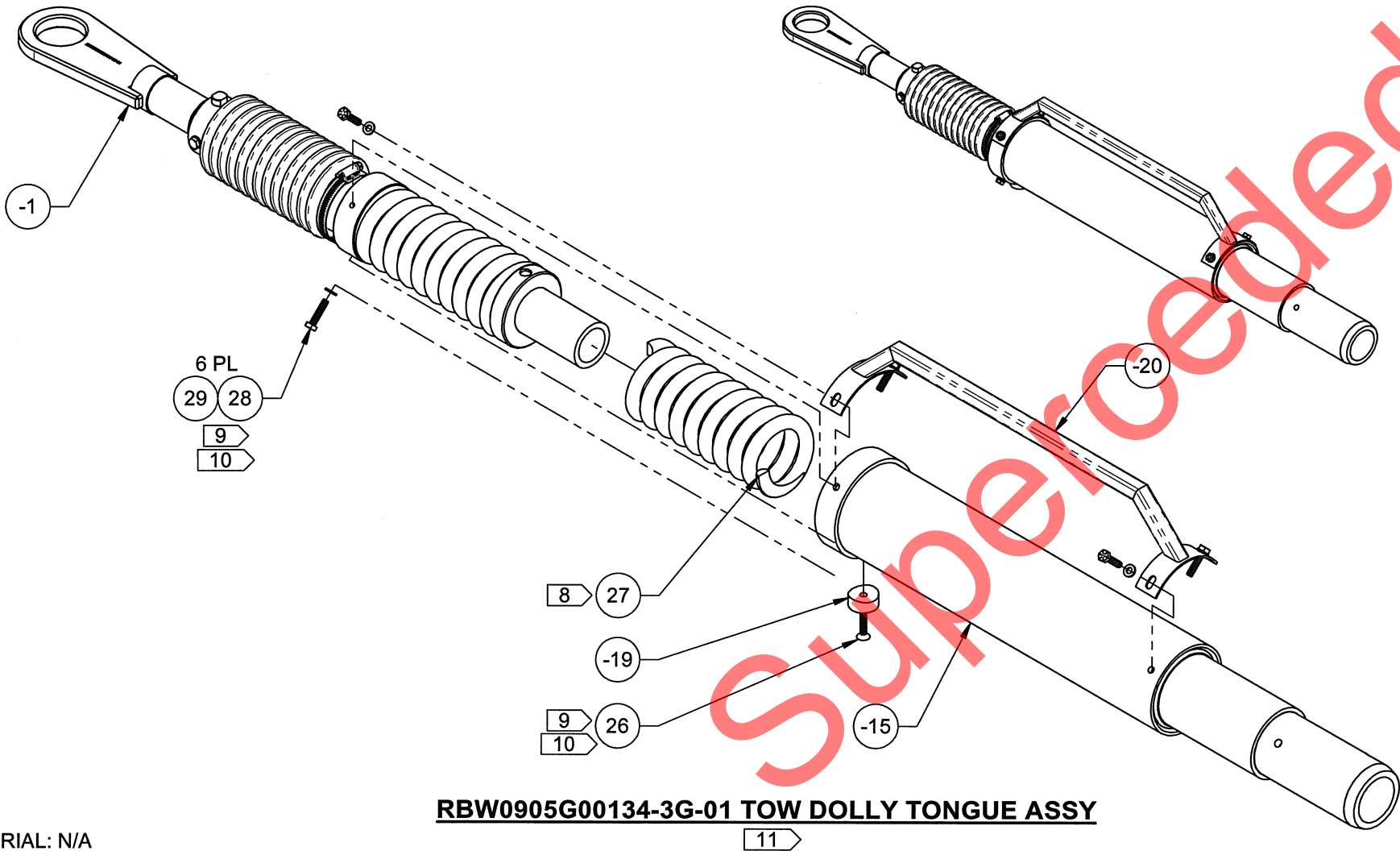


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW0905G00134-3G-01-1	SPRING SECTION ASSY
-15	1	RBW0905G00134-3G-01-15	SPRING COVER ASSY
-19	1	RBW0905G00134-3G-01-19	STOP
-20	1	RBW0905G00134-3G-01-20	HANDLE ASSY
26	1	McMaster#91263A178 OR EQUIV	STEEL ZINC PLATED HEX GRIVE FLAT HEAD SCREW 1/4"-28 X 1-1/4" LG.
27	1	CENTURY SPRING #73358 OR EQUIV	WIRE MUSIC COMPRESSION SPRING 0.594" WIRE DIA. OIL TEMP ASTM A229 CLII, 3.406" OD. X 8.000" LG. CLOSE & GROUND ENDS
28	6	McMaster#92620A701 OR EQUIV.	STEEL GRADE 8 HEX HEAD SCREW 1/4"-28 X 1-1/8" LG.
29	6	NAS1149F0463P	STEEL WASHER 0.265" ID. X 0.500" OD. X 0.063" THK.

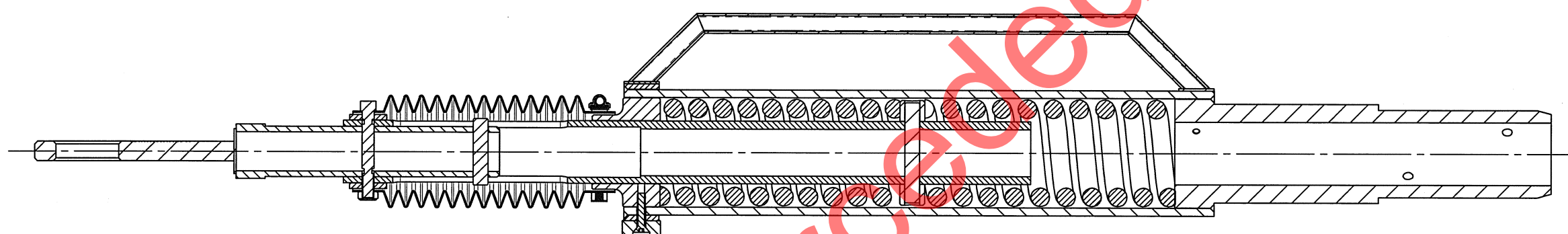
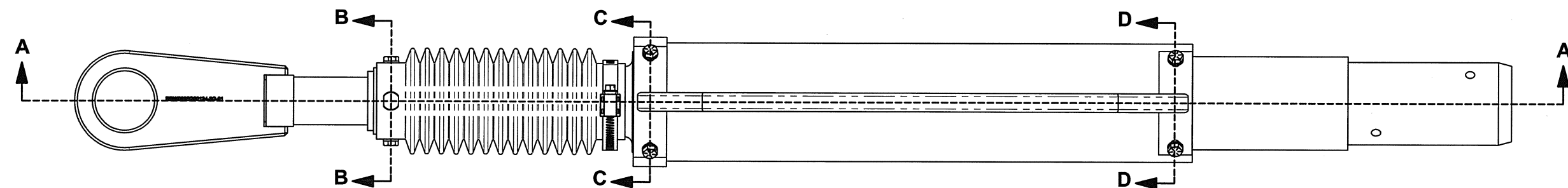


NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) COMPRESS ITEM 27 TO ASSEMBLE ITEM -15
9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 28 AND 26
THEN ASSEMBLE WITH ITEMS -15, -20, -1 AND -19 AND REMOVE EXCESS
10) INSTALL ITEMS 28 AND ITEM 26 HAND TIGHT
11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

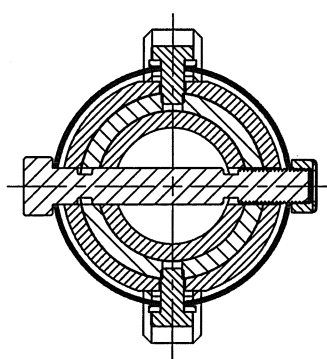
SEE PREVIOUS PDFs FOR OLDER REVs
TEMPLATE UPDATED PER DART HBY STANDARDS
ITEM -041 CHANGED FOR ITEM -20
ITEM -155 CHANGED FOR ITEM -19
ITEM -033 CHANGED FOR ITEM -15
ITEM -013 CHANGED FOR ITEM -1
ITEM -029 AN960-416 CHANGED FOR ITEM 29 NAS1149F0463P
ITEM -191 McMaster#90566A220 CHANGED FOR ITEM 31
McMaster#94945A218
ITEM -001 DELETED
ITEM -003 CHANGED FOR ITEM -9
ITEM -023 CHANGED FOR ITEM -8
ITEM -011 CHANGED FOR ITEM -7
ITEM -235 CHANGED FOR ITEM -14
ITEM -021 CHANGED FOR ITEM -6
ITEM -014 CHANGED FOR ITEM -2
ITEM -015 CHANGED FOR ITEM -3
ITEM -017 CHANGED FOR ITEM -4
ITEM -019 CHANGED FOR ITEM -5
ITEM -005 CHANGED FOR ITEM -13
ITEM -10 ASSY ADDED
ITEM -009 CHANGED FOR ITEM -12
ITEM -007 CHANGED FOR ITEM -11
ITEM -039 CHANGED FOR ITEM -18
ITEM -035 CHANGED FOR ITEM -16
ITEM -037 CHANGED FOR ITEM -17
ITEM -049 CHANGED FOR ITEM -24
ITEM -045 CHANGED FOR ITEM -22
ITEM -043 CHANGED FOR ITEM -21
ITEM -047 CHANGED FOR ITEM -23
ITEM -051 CHANGED FOR ITEM -25
ITEM -2 FINISH CLEAR ANODIZE CHANGED FOR ZINC PLATE
ITEM -3 DIMENSION .79 CHANGED FOR 0.790, DIMENSION .472 +0.002/-0 CHANGED FOR 0.484 STANDARD DRILL SIZE, DIMENSION 2.000 +0/-0.015 CHANGED FOR 2.00 +0/-0.01, DIMENSION .394 +0.002/-0 CHANGED FOR 0.391 +0.005/-0, MATERIAL 6061 CHANGED FOR A513 DOM TUBING, DIMENSION 1.620 CHANGED FOR 1.620 +/-0.003", DIMENSION R0.02 ADDED
ITEM -4 MATERIAL 6061 CHANGED FOR 4130, DIMENSION .472 +0.002/-0 CHANGED FOR 0.484, DIMENSION 2.02 CHANGED FOR 2.01 +0.01/-0
ITEMS -5 & -7 DIMENSION .472 +0/-0.002 CHANGED FOR .472 +0/-0.005, DIMENSION 0.03 X 45° CMF 2 PL ADDED, CENTER DRILL NOTE ADDED, MATERIAL 6061 CHANGED FOR 4130
ITEM -6 DIMENSION $\phi .323 \nabla 1.0 \nabla \phi .44 \times 90^\circ$ REPLACED BY 1/4"-28 UNF, DIMENSION 5X .58 CHANGED FOR 0.60 5 PL, DIMENSION 2.010 CHANGED FOR 2.010 +0.010/-0, DIMENSION 3.480 CHANGED FOR 3.48 +0/-0.01, MATERIAL 6061 CLEAR ANODIZE CHANGED FOR 4140 (28-32 RC) ZINC PLATE
ITEM -8 MATERIAL 6061 CLEAR ANODIZE CHANGED FOR 4140 (28-32 RC) ZINC PLATE, DIMENSION .257 CHANGED FOR 0.281, DIMENSION .394 +0.002/-0 CHANGED FOR 0.391 +0.005/-0, DIMENSION 2.010 CHANGED FOR 2.01 +0.01/-0
ITEM -11 MATERIAL SS304 CHANGED FOR A513 DOM TUBING, DIMENSION .472 +0.002/-0 CHANGED FOR 0.484, DIMENSION .394 +0.002/-0 CHANGED FOR 0.391 +0.005/-0, DIMENSION 1.610 CHANGED FOR 1.610 +0/-0.005, DIMENSION 1.73 CHANGED FOR 1.735, DIMENSION R0.008 MAX ADDED
ITEM -12 MATERIAL 304 S.S CHANGED FOR A36/1018/1020/1025 HR
ITEM -13 MATERIAL 304 S.S CHANGED FOR 4130, DIMENSION 1.75 CHANGED FOR 1.750
ITEM -14 DRAWING ADDED
ITEM -15 FINISH WAS DUAL FINISH CLEAR ANODIZE AND POWDER COAT IS ZINC PLATE
ITEM -16 HOLES ADDED, MATERIAL 6061 CHANGED FOR A513 DOM TUBING, DIMENSION 3.50 CHANGED FOR 3.50 +0.01/-0, DIMENSION 4.00 CHANGED FOR 4.00 +0/-0.010
ITEM -17 HOLES ADDED, MATERIAL 6061 CHANGED FOR 4130, DIMENSION 3.480 CHANGED FOR 3.480 +0/-0.005, DIMENSION R0.008 MAX 2 PL ADDED
ITEM -18 HOLES ADDED, MATERIAL 6061 CHANGED FOR 4130
ITEM -19 MATERIAL WHITE DELRIN CHANGED FOR BLACK DELRIN
ITEM -20 FINISH POWDER COAT YELLOW CHANGED FOR ZINC
ITEMS -21, -22 & -23 MATERIAL STEEL SQ. TUBING CHANGED FOR A513 DOM TUBING
ITEMS -24 & -25 MATERIAL 1018 CHANGED FOR A36/1018/1020/1025

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 1 OF 27
APPROVED	VP	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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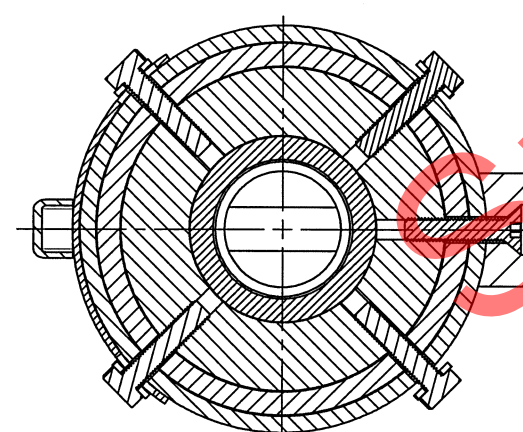
8 7 6 5 4 3 2 1



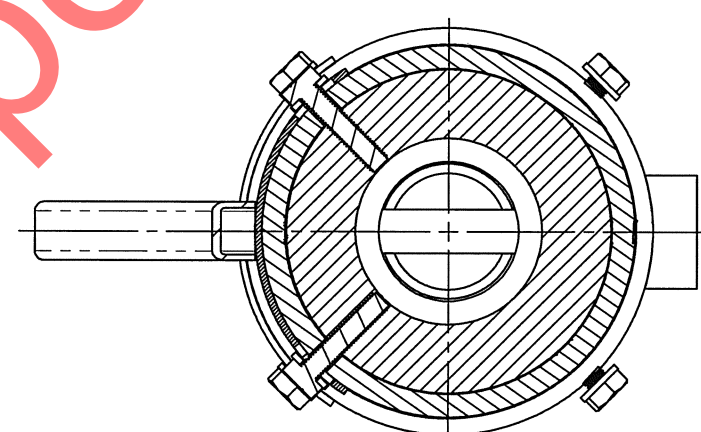
SECTION A-A




SECTION B-B



SECTION C-C

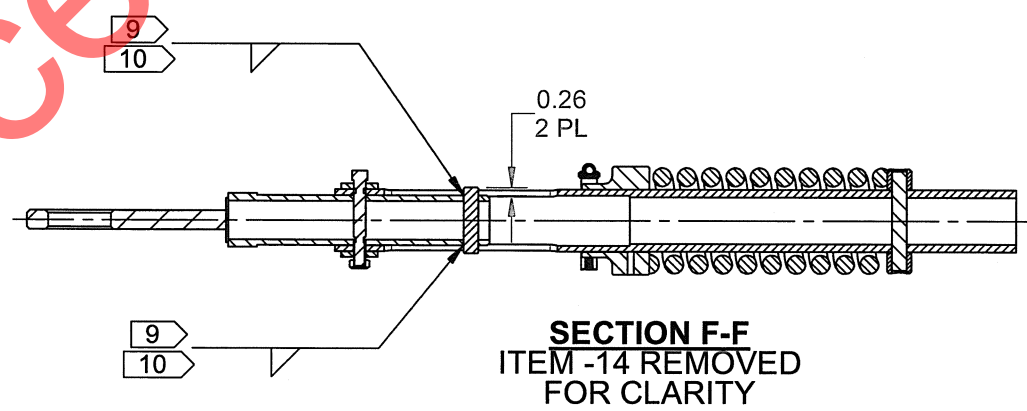
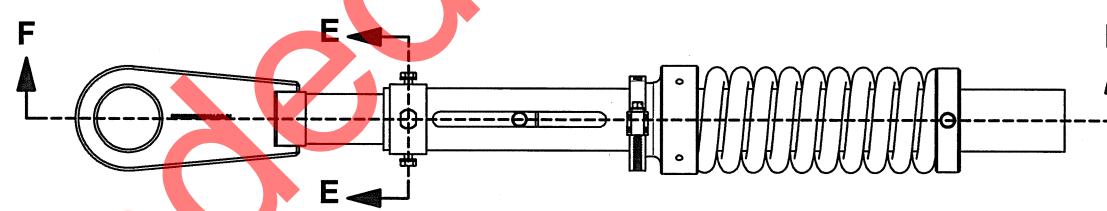
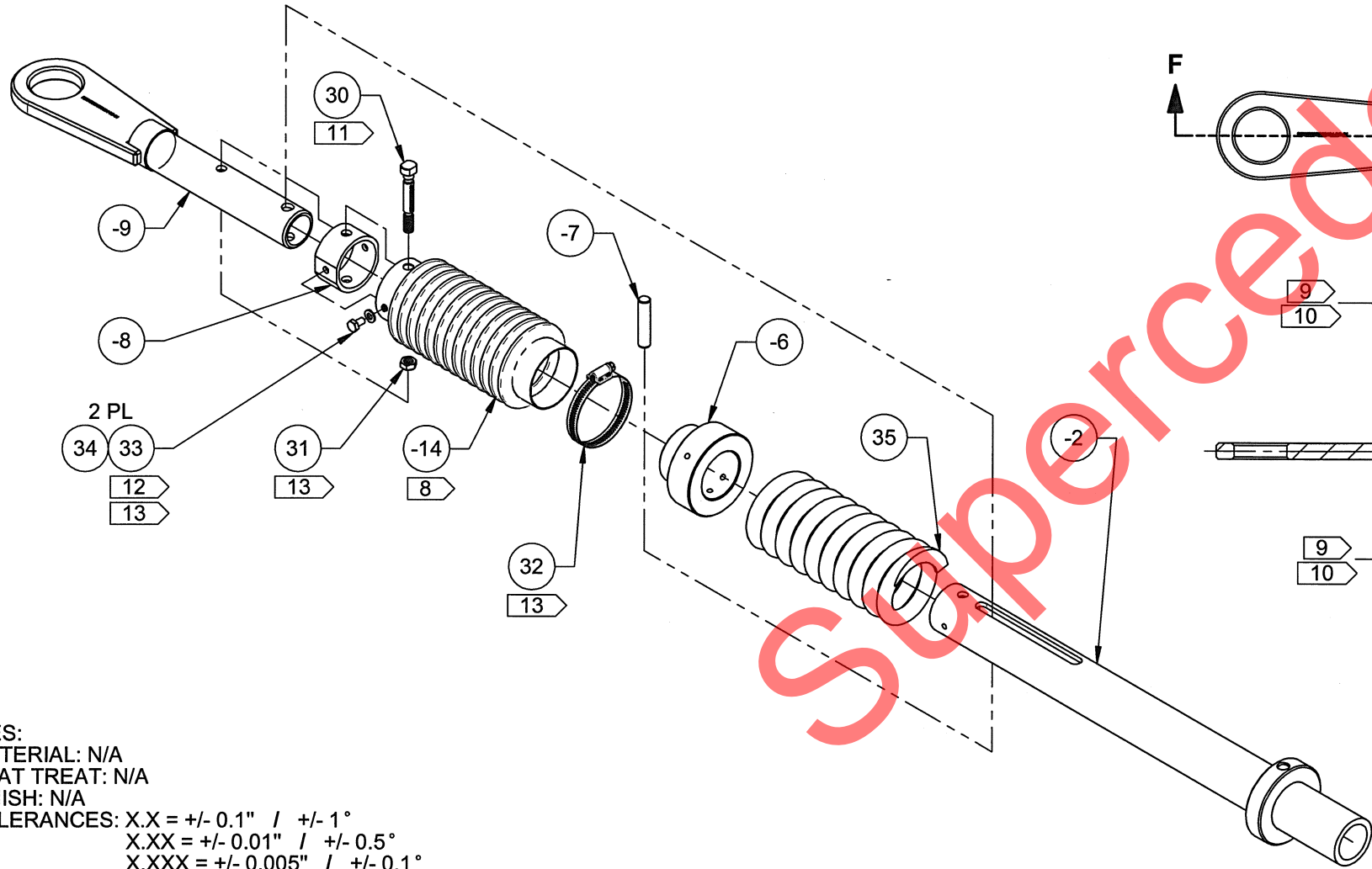
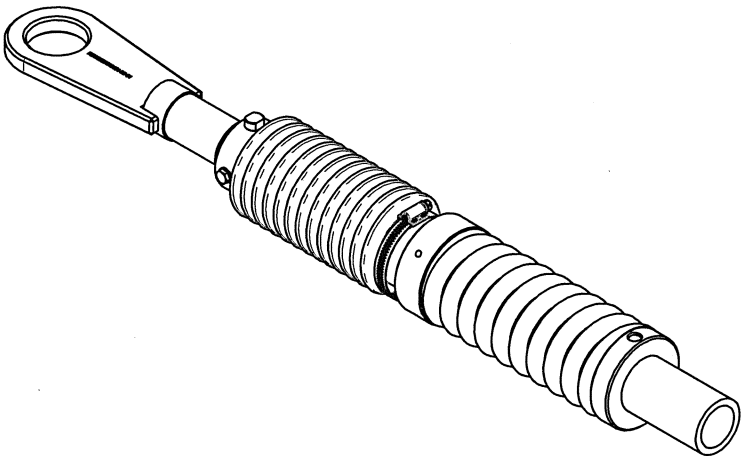


SECTION D-D

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MBB	TOOL PART #	REV. G		
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 2 OF 27		
APPROVED	WY	TITLE	SCALE		
		TOW DOLLY TONGUE ASSY	NTS		
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW0905G00134-3G-01-2	GUIDE ASSY
-6	1	RBW0905G00134-3G-01-6	SPRING FRONT STOP
-7	1	RBW0905G00134-3G-01-7	SLIDE PIN
-8	1	RBW0905G00134-3G-01-8	FRONT COLLAR
-9	1	RBW0905G00134-3G-01-9	TONGUE ASSY
-14	1	RBW0905G00134-3G-01-14	C.V. BOOT
30	1	RBW0905G01652-3G	TONGUE SHEAR BOLT
31	1	McMaster#94945A218 OR EQUIV	STEEL GRADE 8 ZINC YELLOW-CHROMATE PLATED THIN NYLON-INSERT LOCKNUT 3/8"-24
32	1	McMaster#5415K220 OR EQUIV	SS301 WORM-DRIVE CLAMPS 1/2" WIDE BAND X 2-1/16" TO 3" CLAMP ID
33	2	AN4-3A	BOLT
34	2	NAS1149F0463P	STEEL WASHER 0.265" ID. X 0.500" OD. X 0.063" THK.
35	1	CENTURY SPRING #73358 OR EQUIV	WIRE MUSIC COMPRESSION SPRING 0.594" WIRE DIA. OIL TEMP ASTM A229 CLII, 3.406" OD. X 8.000" LG. CLOSE & GROUND ENDS

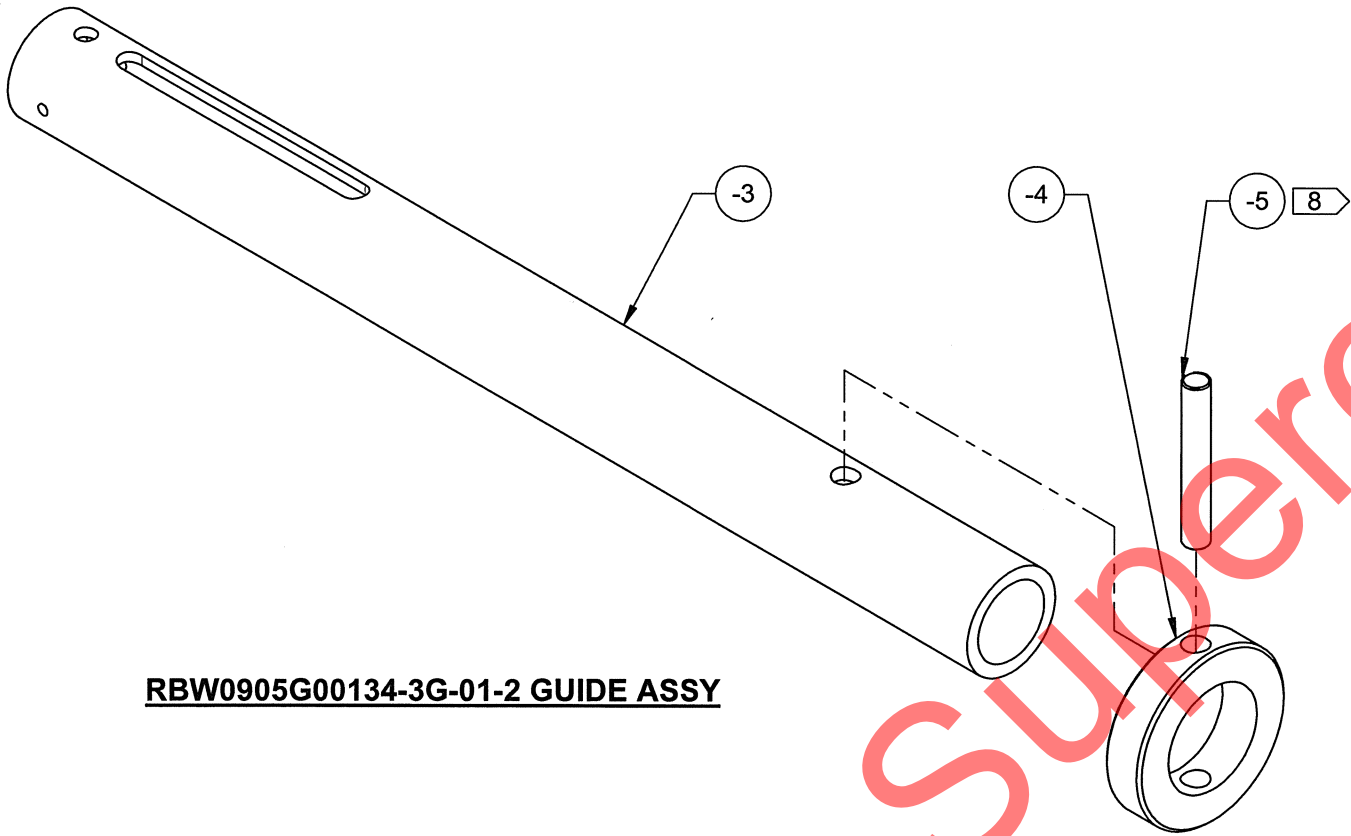


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) ASSEMBLE ITEM -14 WITH ITEMS 30, 31, 34 AND 33 TO ITEMS -8 AND -9, THEN COMPRESS ITEM -14 TEMPORARILY TO ALLOW CLEARANCE FOR WELDING ITEM -7 WITH ITEM -9
 - 9) TACK WELD ITEM -7 WITH ITEM -9 TOP AND BOTTOM AS SHOWN, ITEM -9 MUST SLIDE FREELY INTO ITEM -2
 - 10) REMOVE WELD SPATTERS
 - 11) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 30 THEN ASSEMBLE WITH ITEM 31, AND REMOVE EXCESS
 - 12) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 33 THEN ASSEMBLE WITH ITEM -8, AND REMOVE EXCESS
 - 13) INSTALL ITEMS 31, 32 AND 33 HAND TIGHT

RBW0905G00134-3G-01-1 SPRING SECTION ASSY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 3 OF 27
APPROVED		TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
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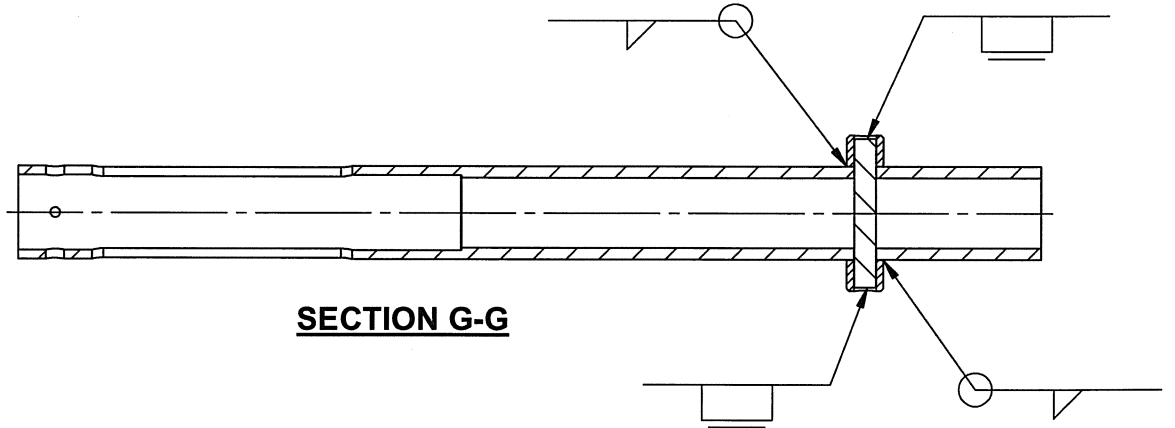
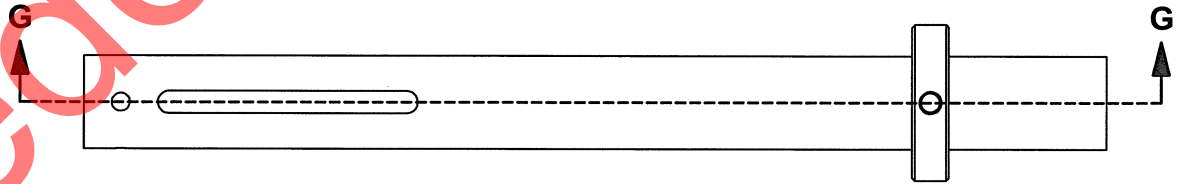
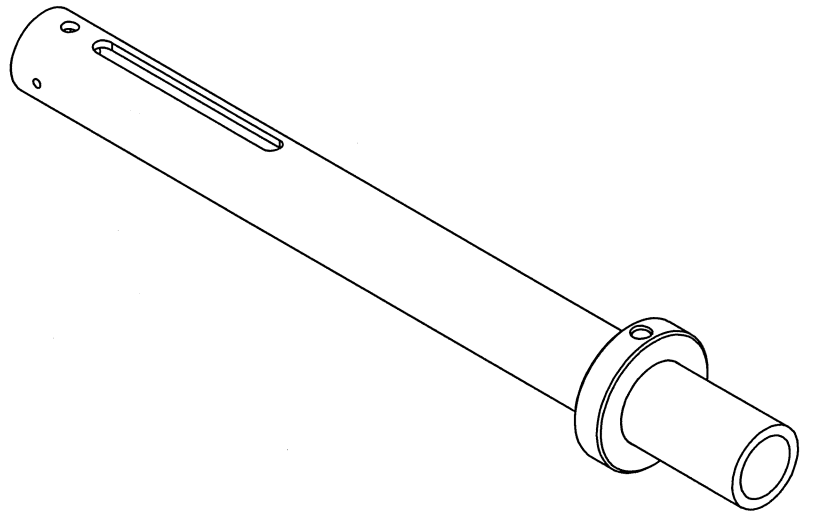
ITEM #	QTY	PART #	PART TITLE
-3	1	RBW0905G00134-3G-01-3	DRAW TUBE
-4	1	RBW0905G00134-3G-01-4	SPRING CENTER STOP
-5	1	RBW0905G00134-3G-01-5	CENTER STOP PIN




RBW0905G00134-3G-01-2 GUIDE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) ASSEMBLE ITEM -5 CENTERED WITH ITEM -4
- 9) REMOVE ALL WELD SPATTERS



SECTION G-G

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 4 OF 27
APPROVED		TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS 
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8 7 6 5 4 3 2 1

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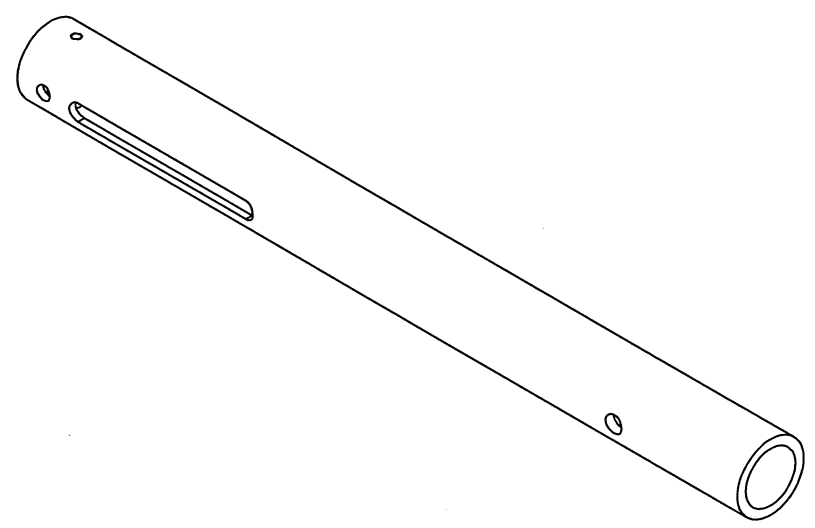
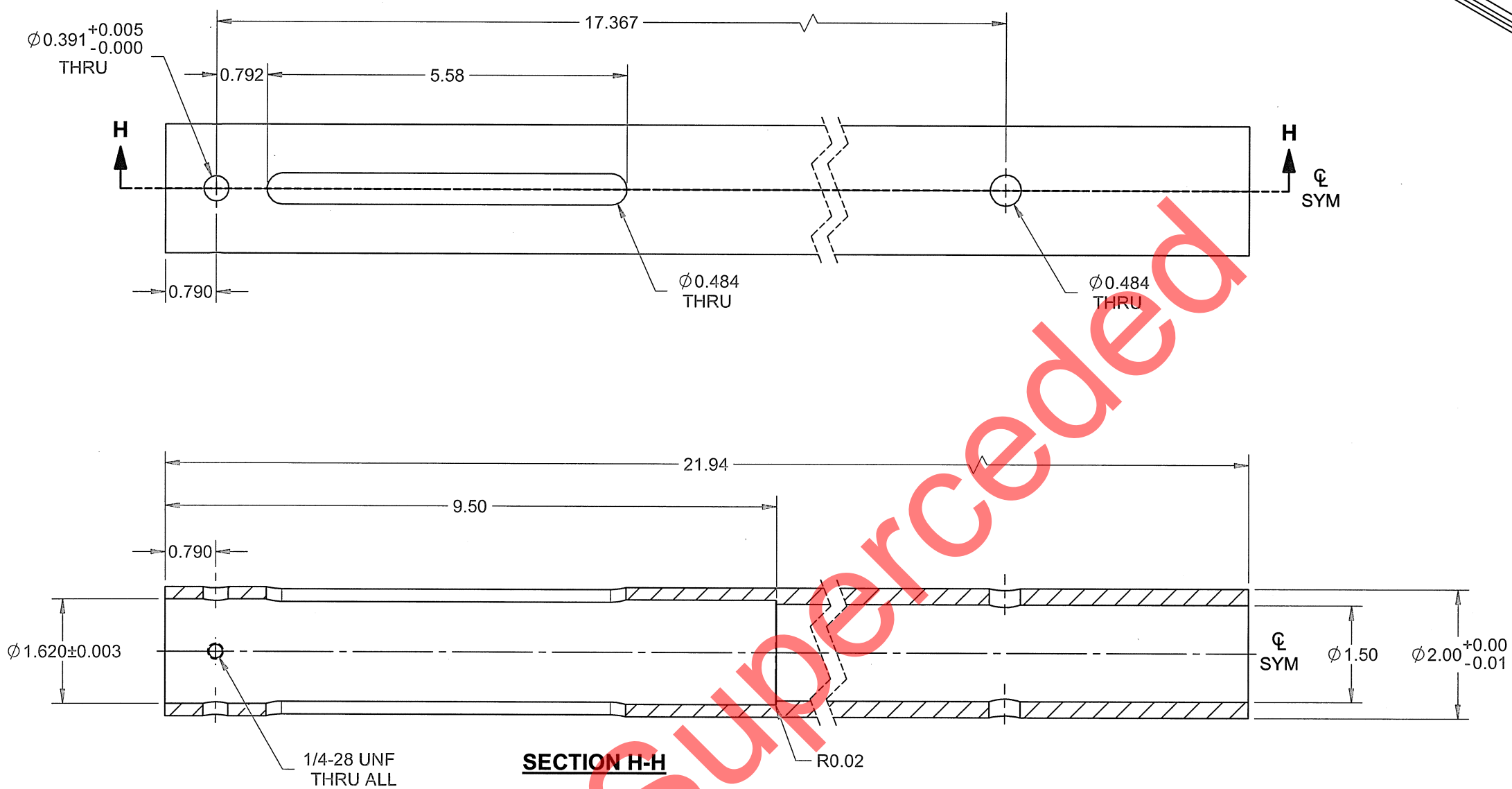
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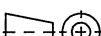
B

B



RBW0905G00134-3G-01-3 DRAW TUBE

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. G SHEET 5 OF 27			
DRAWN	VM						
CHECKED	MBB	TOOL PART #	RBW0905G00134-3G-01				
MFG. APPR.	DP	TITLE					
APPROVED		TOW DOLLY TONGUE ASSY	SCALE NTS				
DATE	3/8/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

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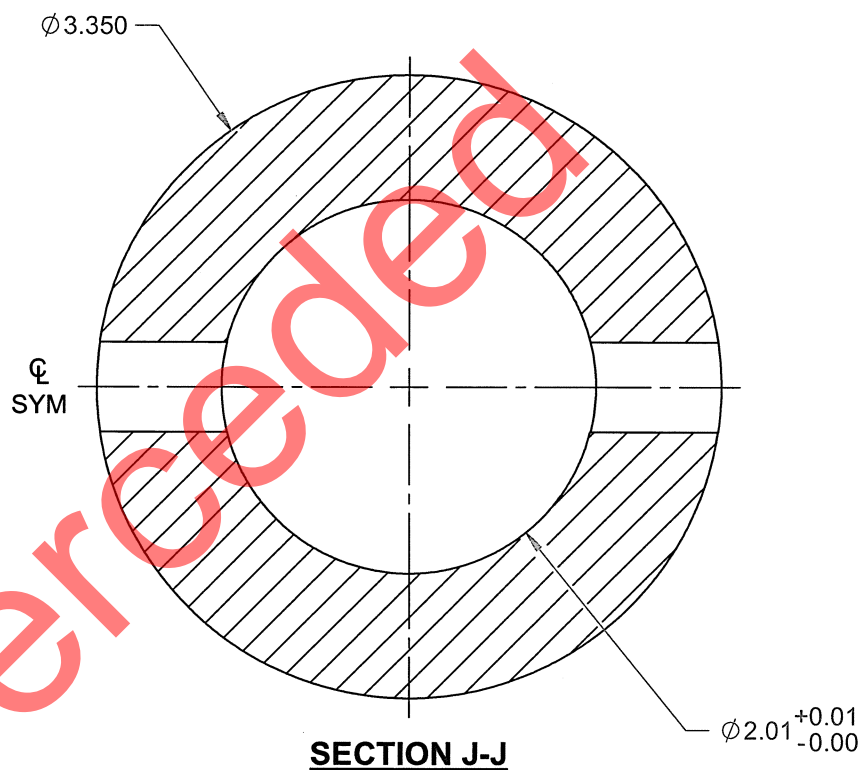
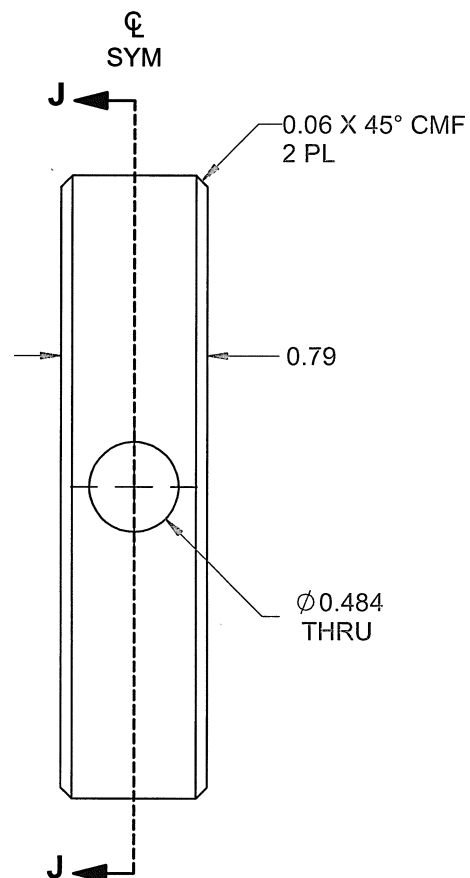
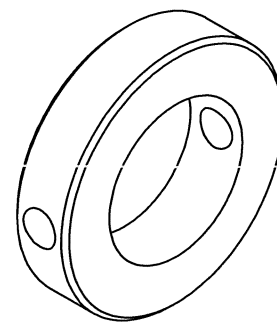
A

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**RBW0905G00134-3G-01-4 SPRING CENTER STOP****NOTES:**

- 1) MATERIAL: 4130
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 6 OF 27
APPROVED	VM	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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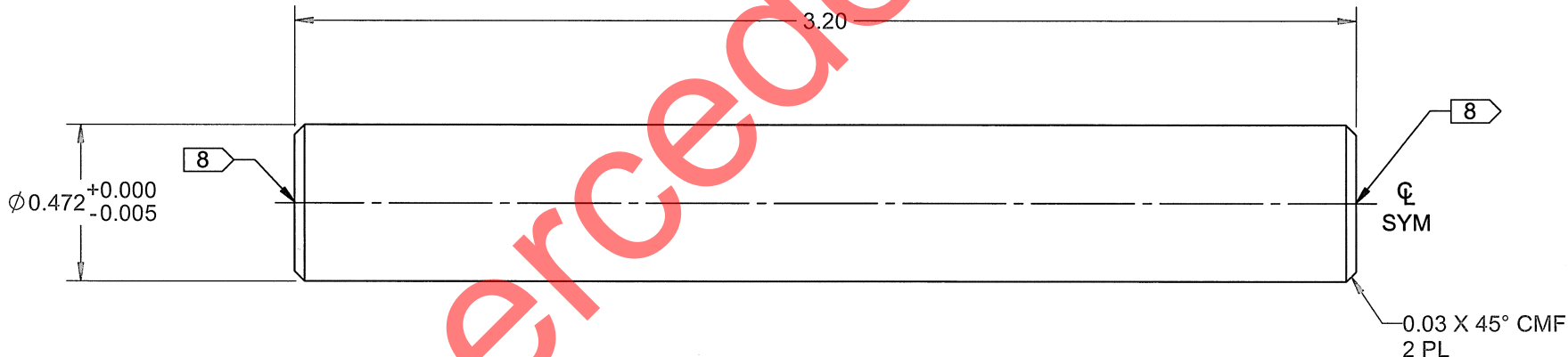
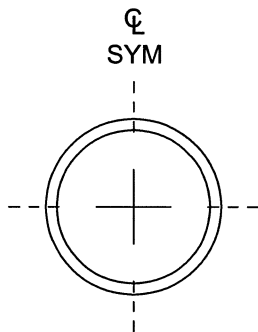
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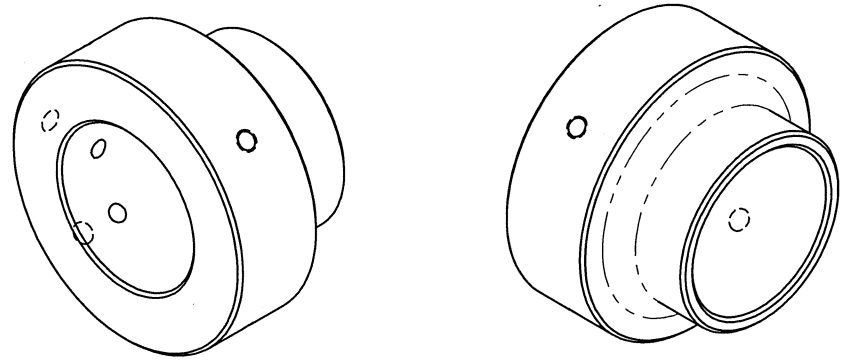
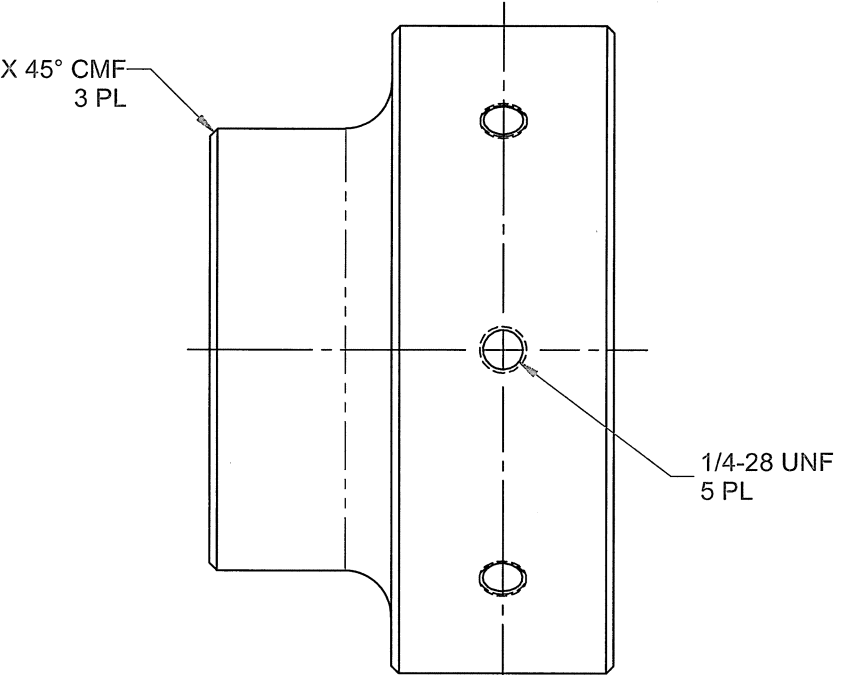
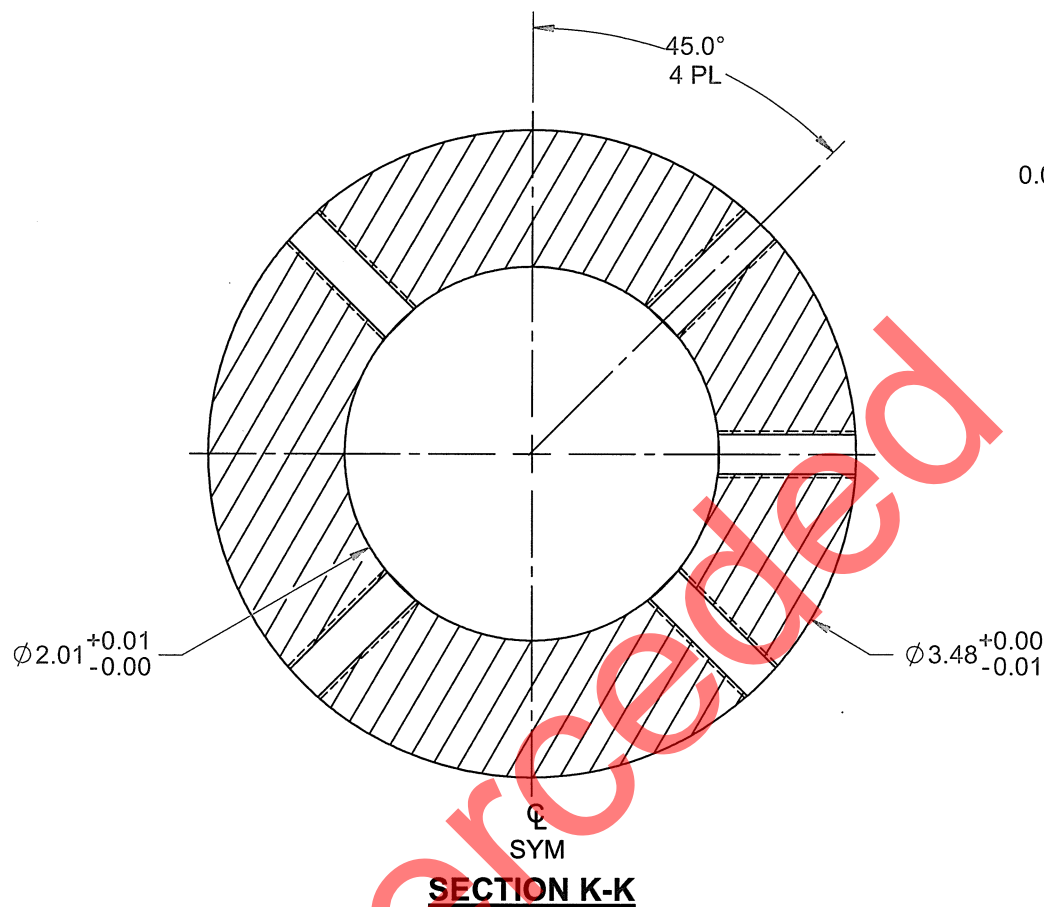
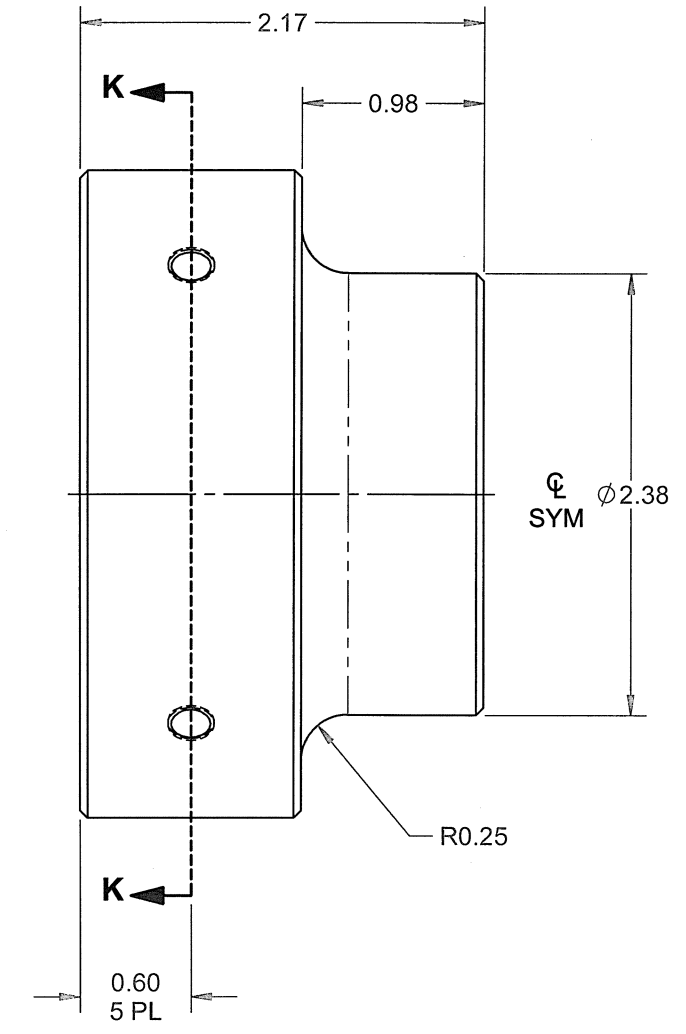
RBW0905G00134-3G-01-5 CENTER STOP PIN



NOTES:

- 1) MATERIAL: 4130
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 7 OF 27
APPROVED		TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS 
DATE	3/8/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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RBW0905G00134-3G-01-6 SPRING FRONT STOP

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 8 OF 27
APPROVED	VM	TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
DATE	3/8/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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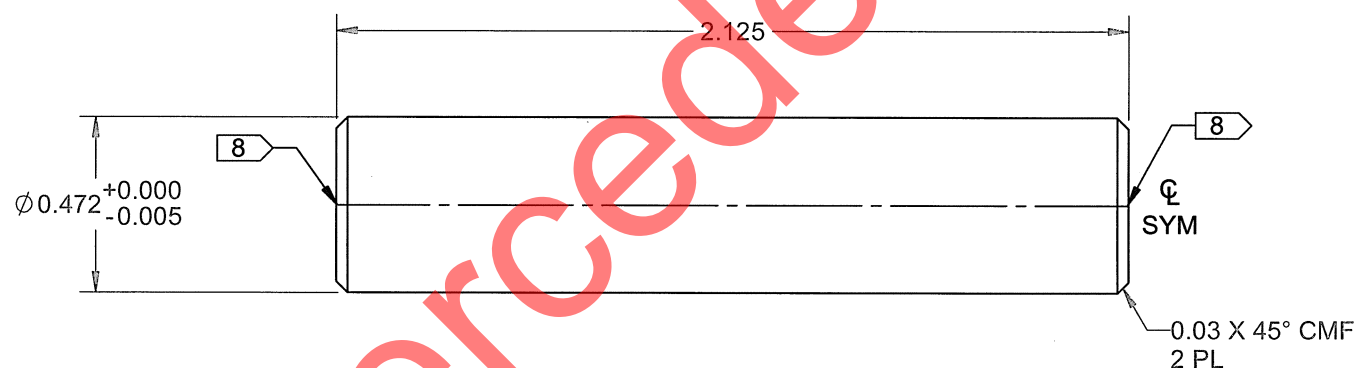
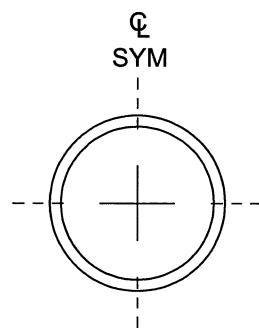
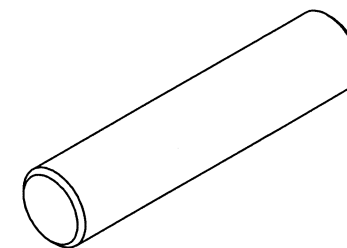
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RBW0905G00134-3G-01-7 SLIDE PIN

NOTES:

- 1) MATERIAL: 4130
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 9 OF 27
APPROVED	VM	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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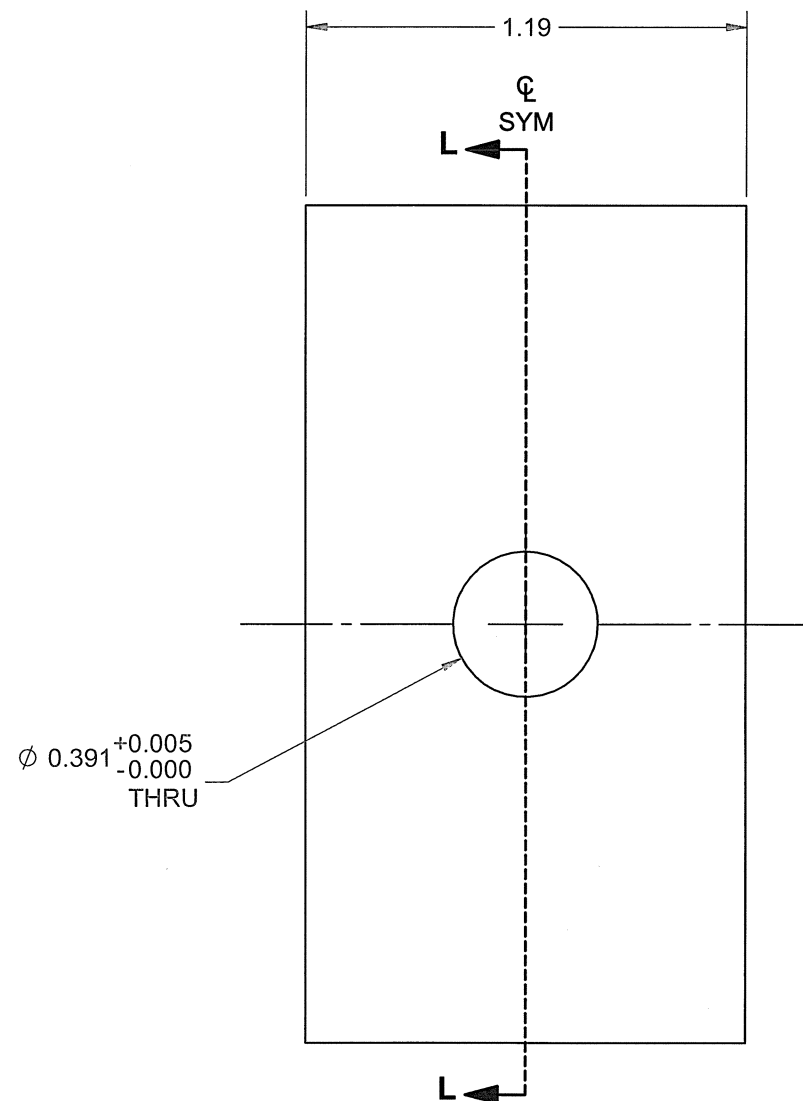
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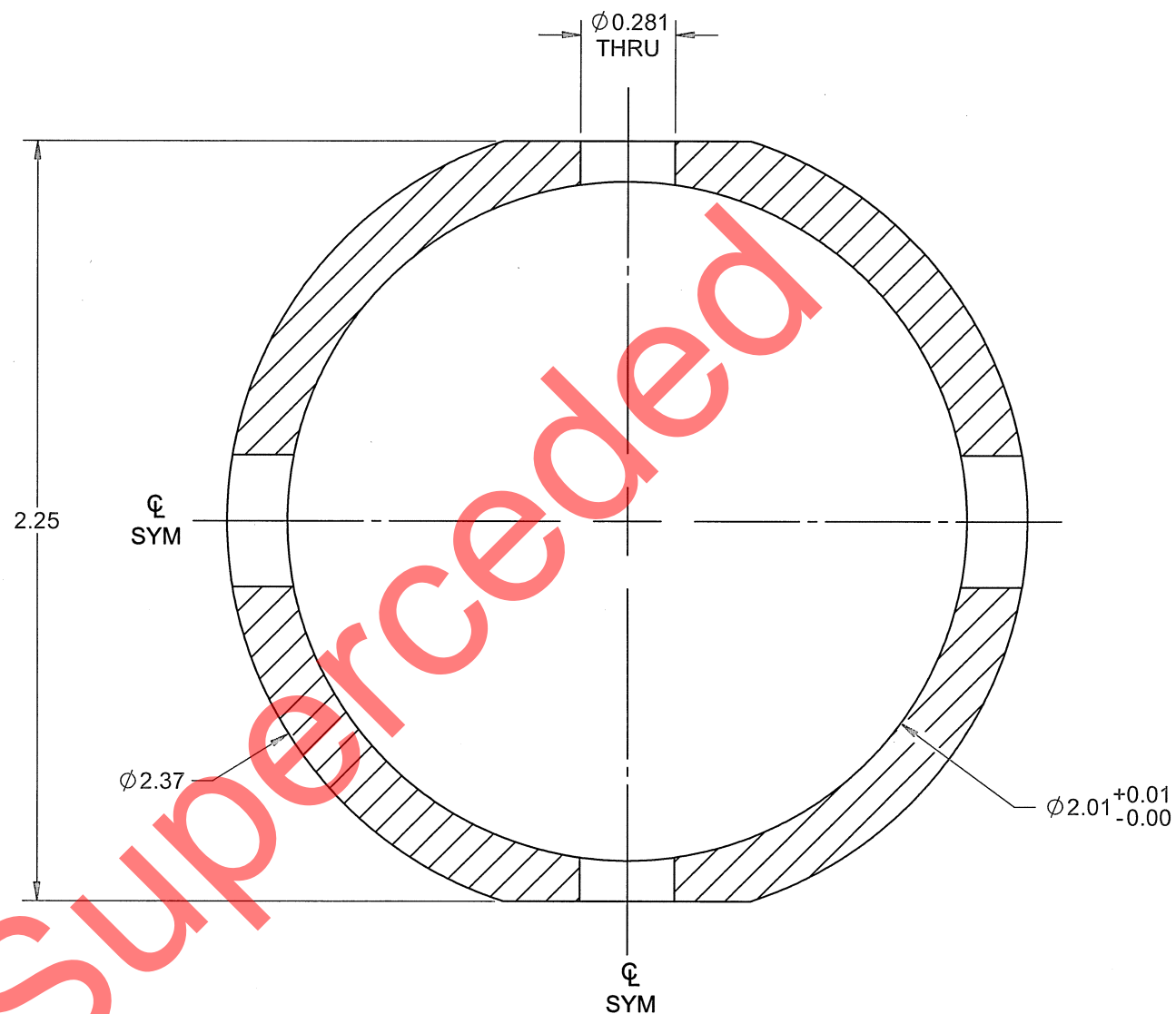
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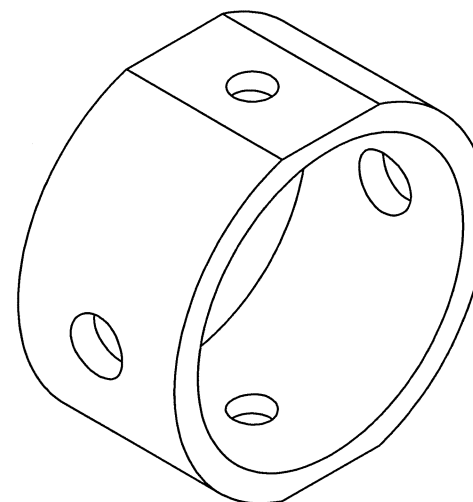
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RBW0905G00134-3G-01-8 FRONT COLLAR




SECTION L-L

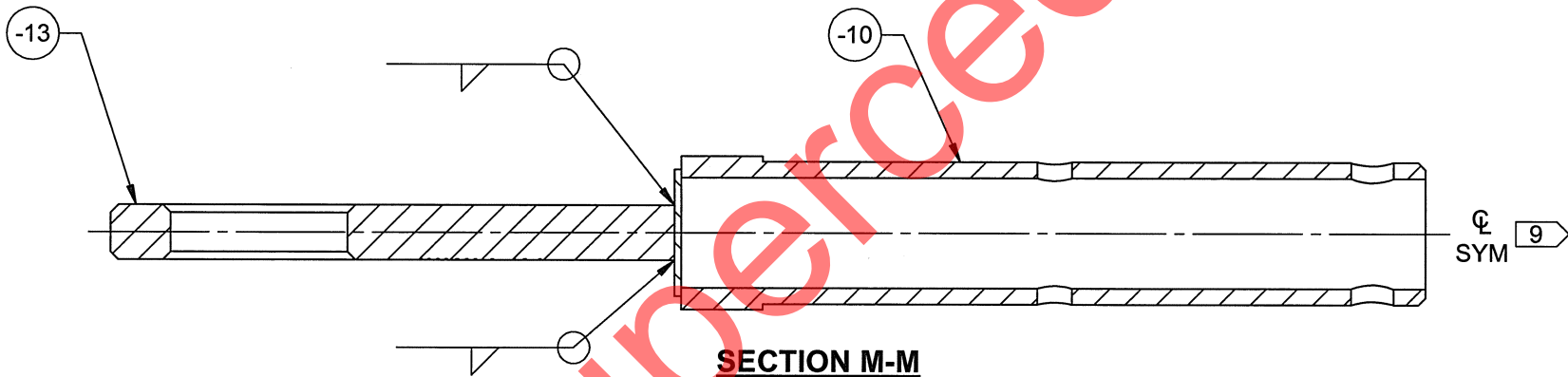
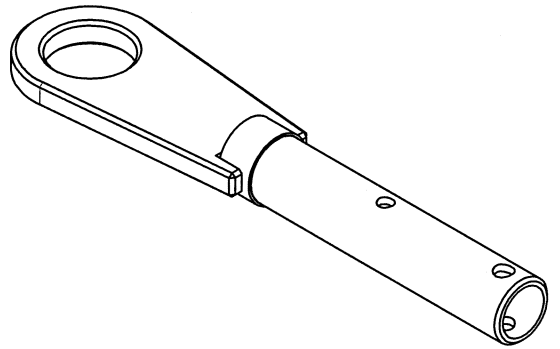
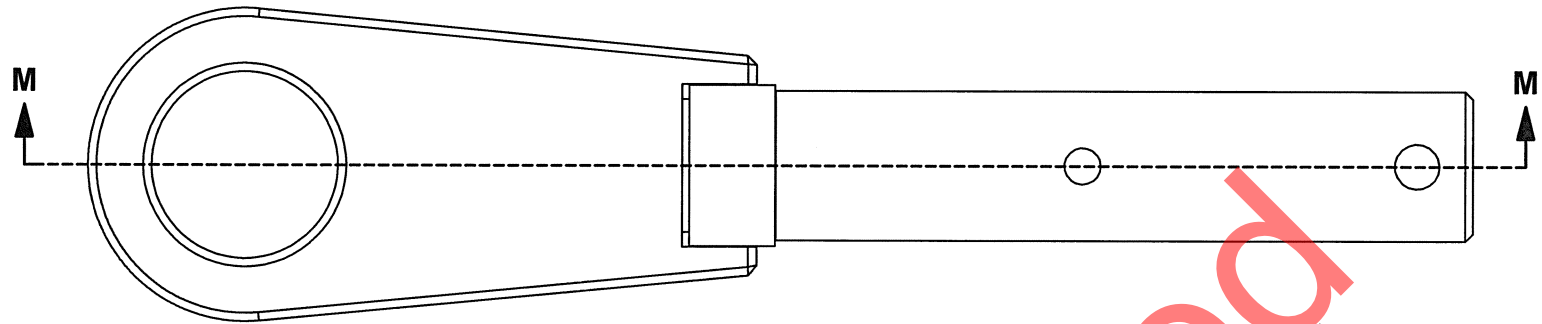


NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
DRAWN	VM			
CHECKED	MBB	TOOL PART #	RBW0905G00134-3G-01	
MFG. APPR.	DP	TITLE		
APPROVED		TOW DOLLY TONGUE ASSY	SCALE NTS	SHEET 10 OF 27
DATE	3/8/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD		
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ITEM #	QTY	PART #	PART TITLE
-10	1	RBW0905G00134-3G-01-10	TONGUE TUBE ASSY
-13	1	RBW0905G00134-3G-01-13	TONGUE

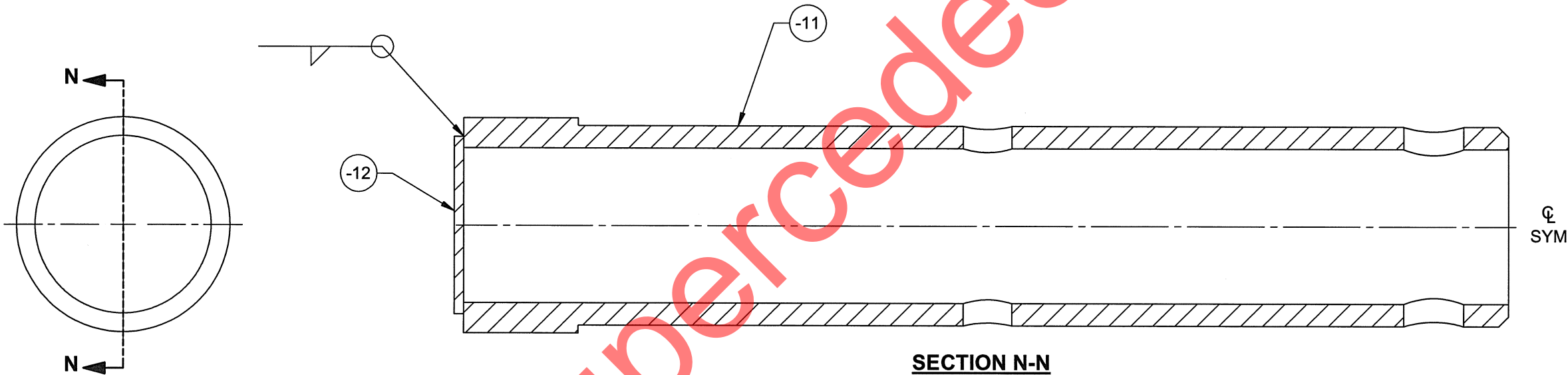
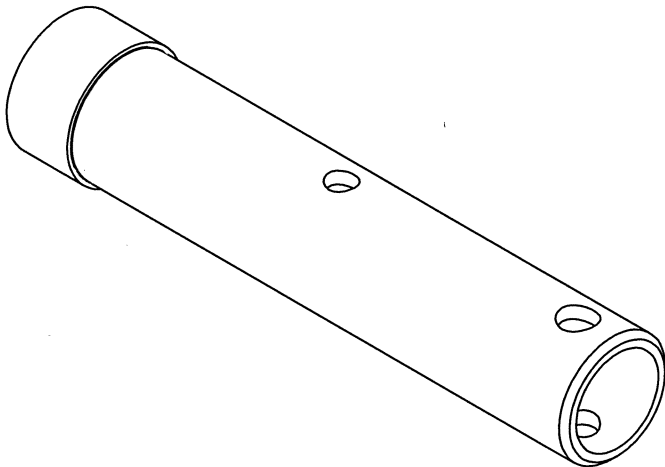


RBW0905G00134-3G-01-9 TONGUE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS
 - 9) ITEM -10 AND ITEM -13 MUST BE CENTERED WITH EACH OTHER BEFORE WELDING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 11 OF 27
APPROVED	VM	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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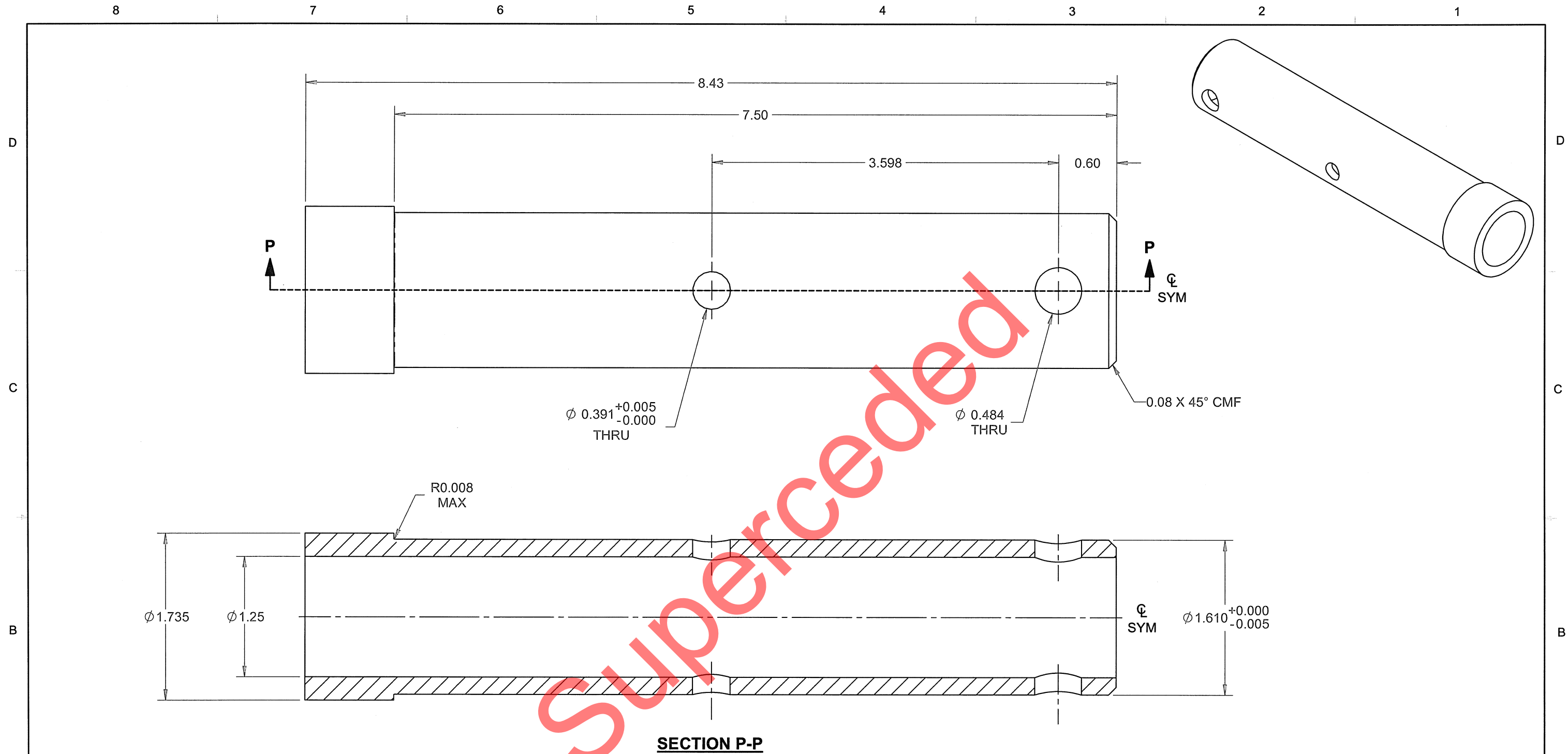
ITEM #	QTY	PART #	PART TITLE
-11	1	RBW0905G00134-3G-01-11	TONGUE TUBE
-12	1	RBW0905G00134-3G-01-12	TONGUE CAP



RBW0905G00134-3G-01-10 TONGUE TUBE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 12 OF 27
APPROVED		TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
DATE	3/8/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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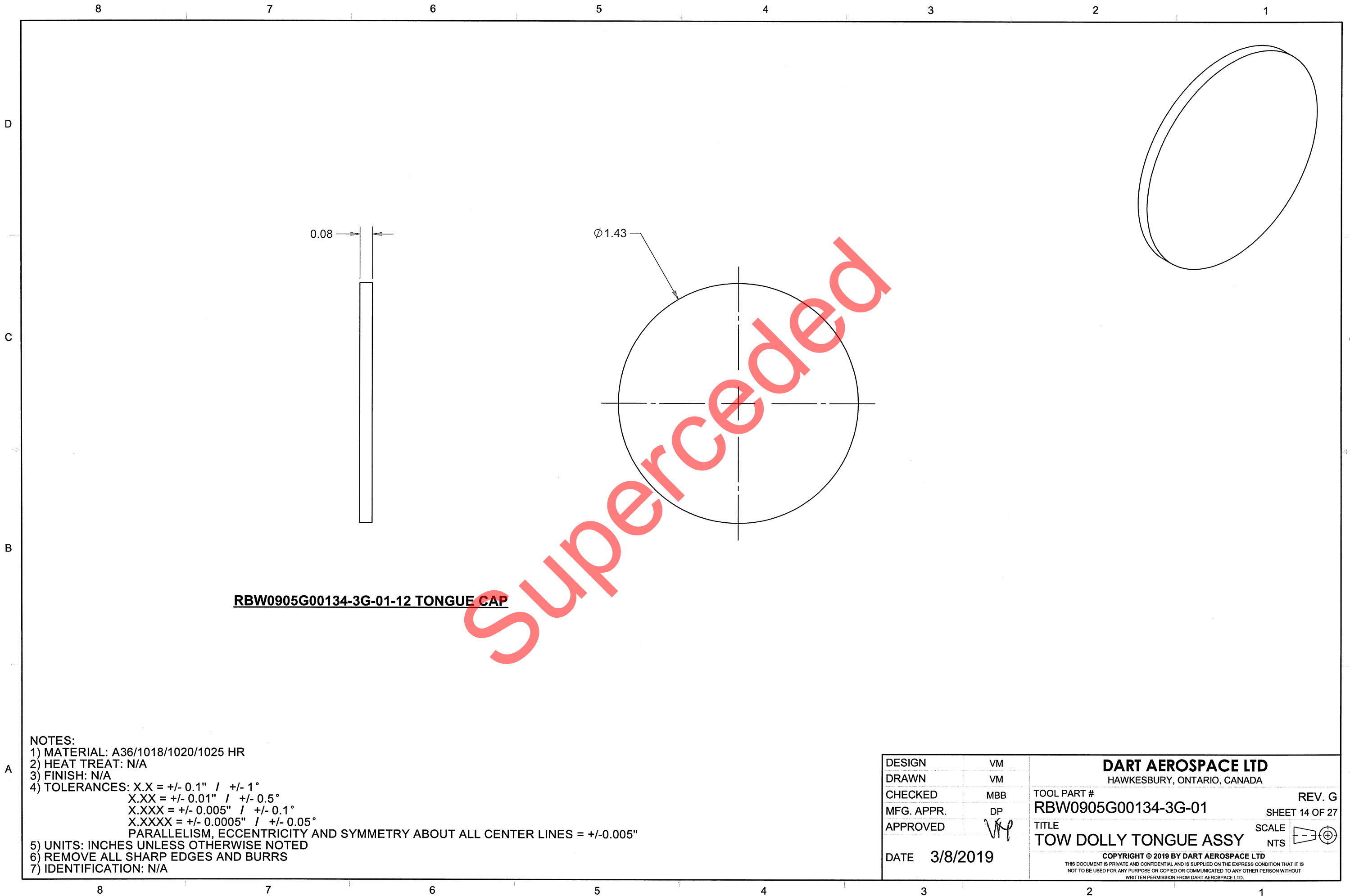


RBW0905G00134-3G-01-11 TONGUE TUBE

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 13 OF 27
APPROVED	VM	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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RBW0905G00134-3G-01-12 TONGUE CAP

NOTES:
1) MATERIAL: A36/1018/1020/1025 HR
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 14 OF 27
APPROVED	VM	TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
DATE	3/8/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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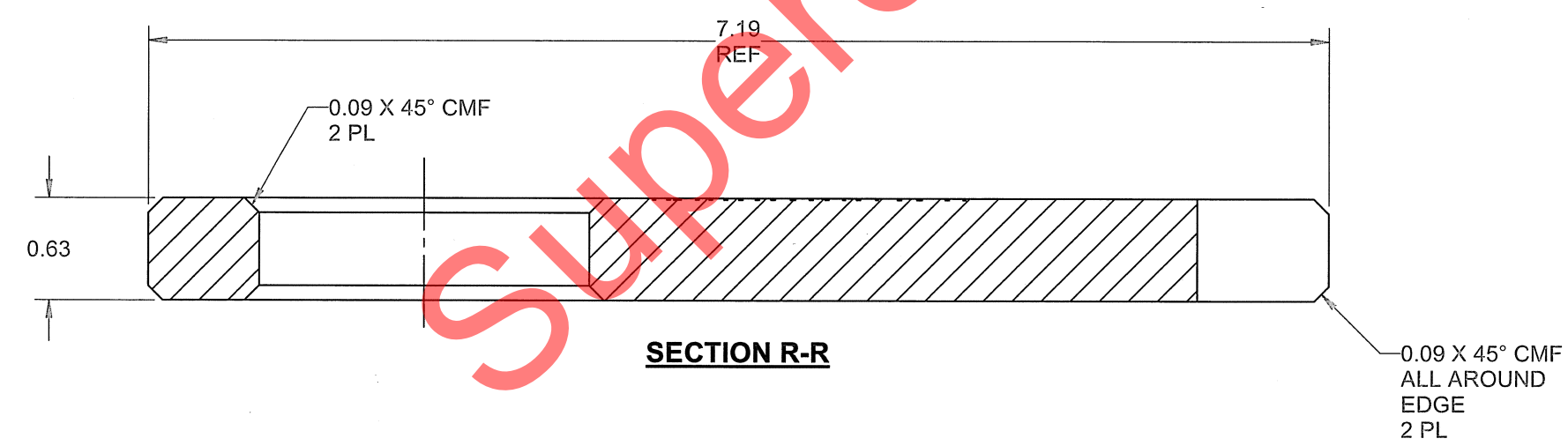
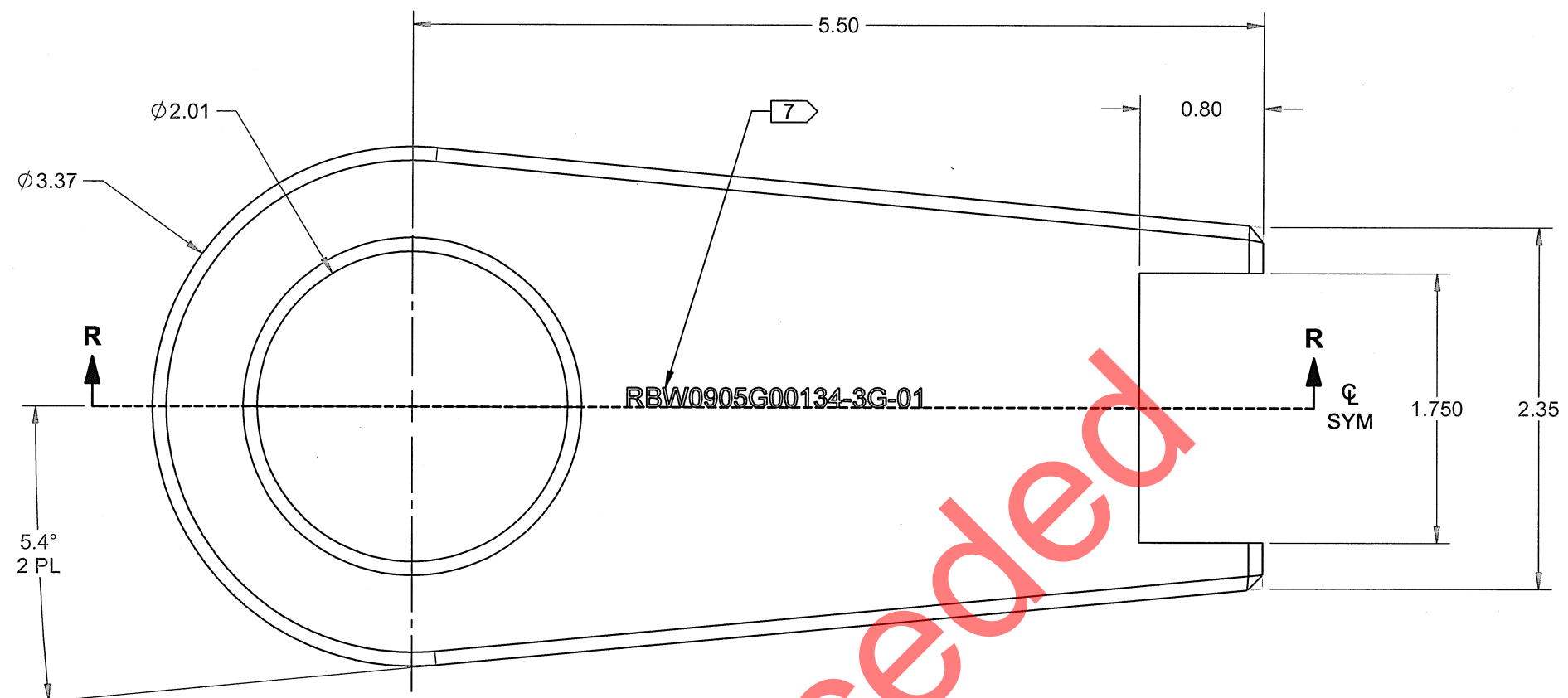
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SECTION R-R

RBW0905G00134-3G-01-13 TONGUE

- NOTES:
- 1) MATERIAL: 4130
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 15 OF 27
APPROVED	VM	TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
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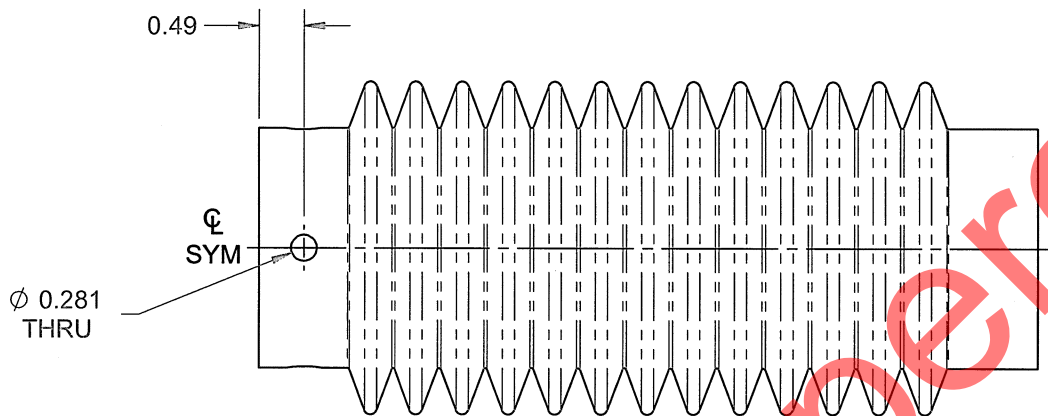
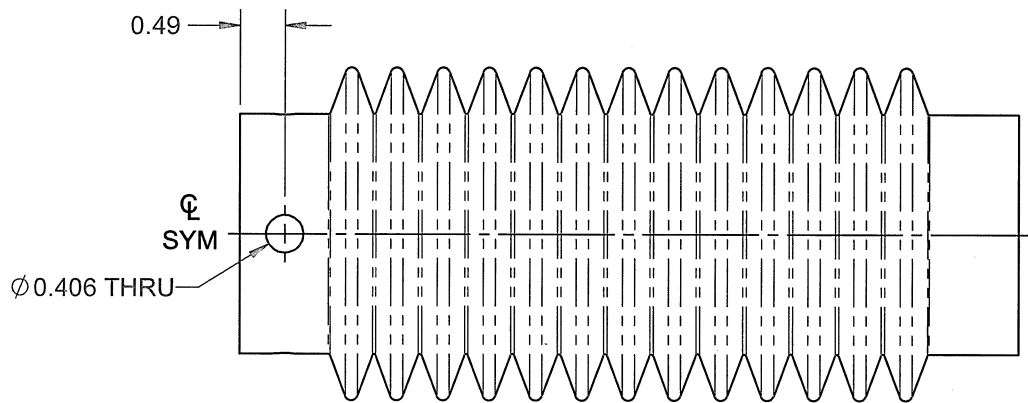
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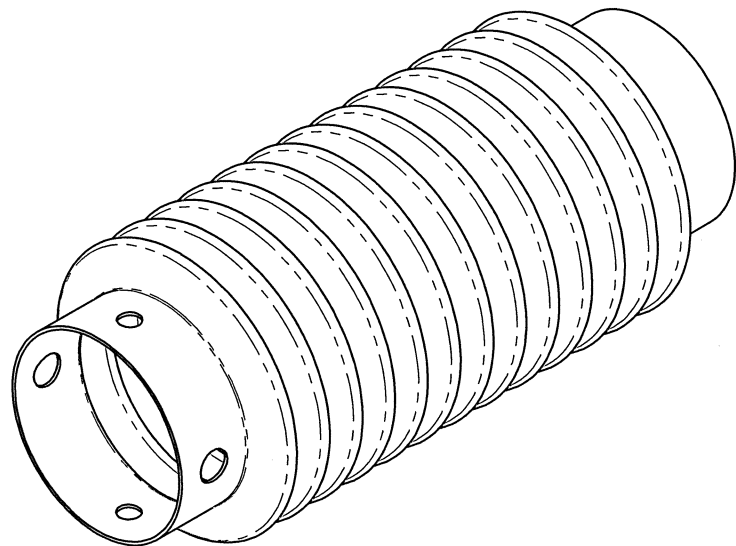
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RBW0905G00134-3G-01-14 C.V. BOOT



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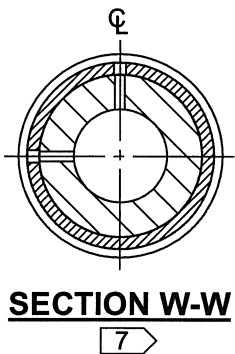
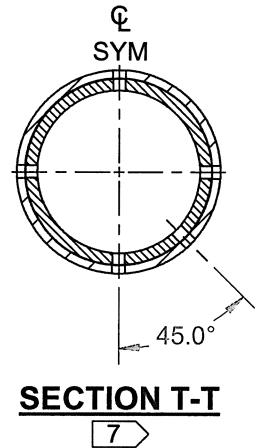
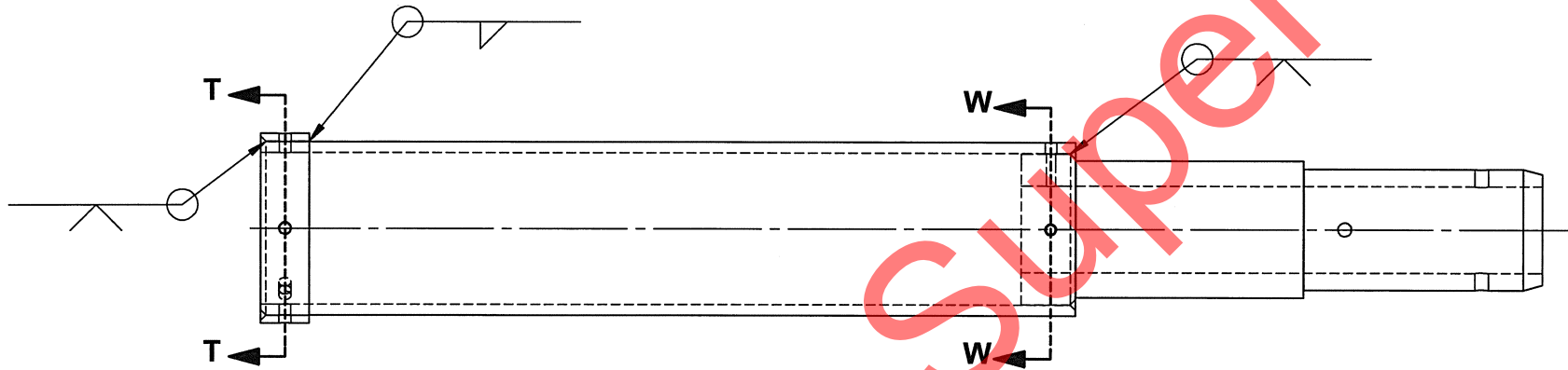
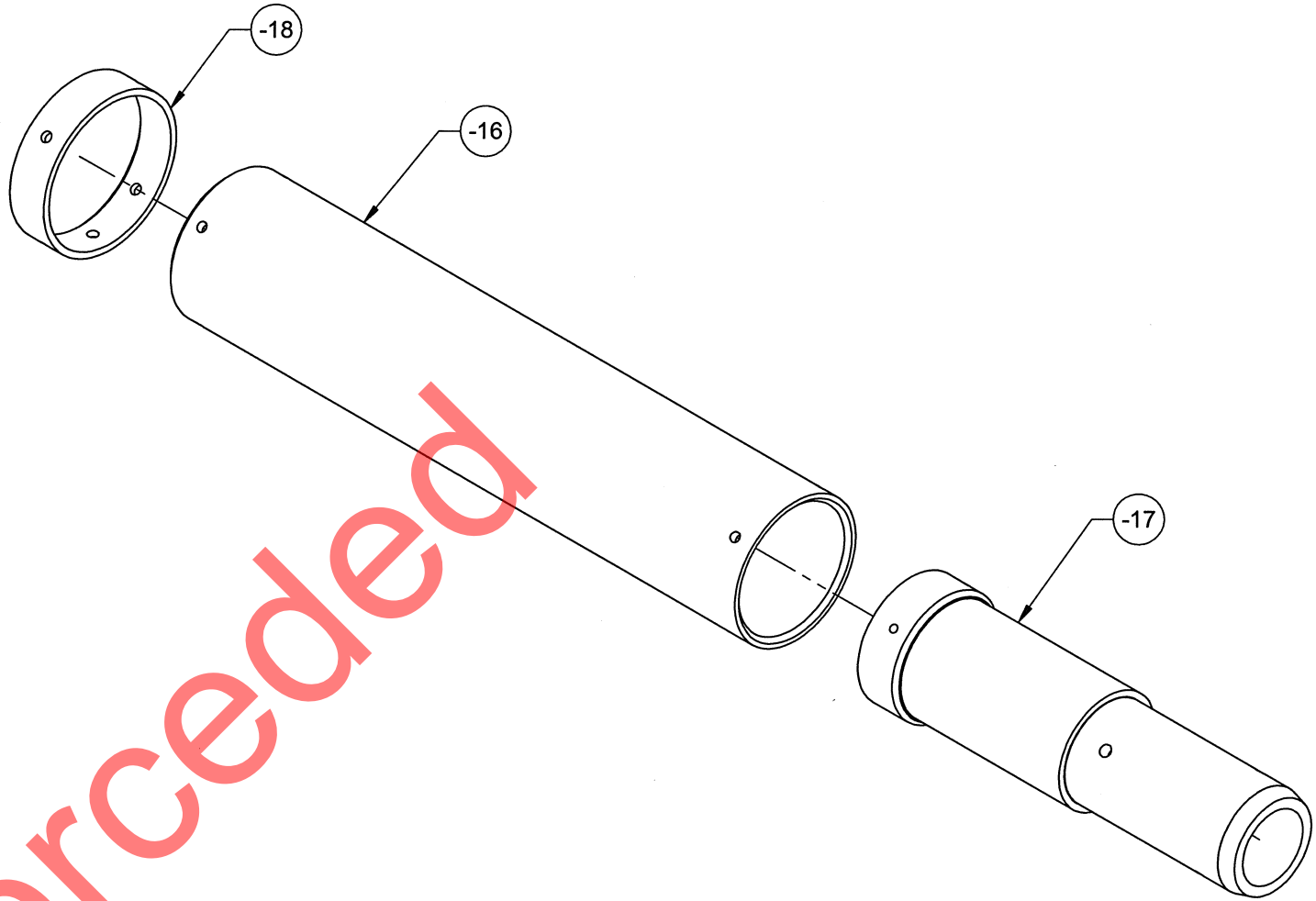
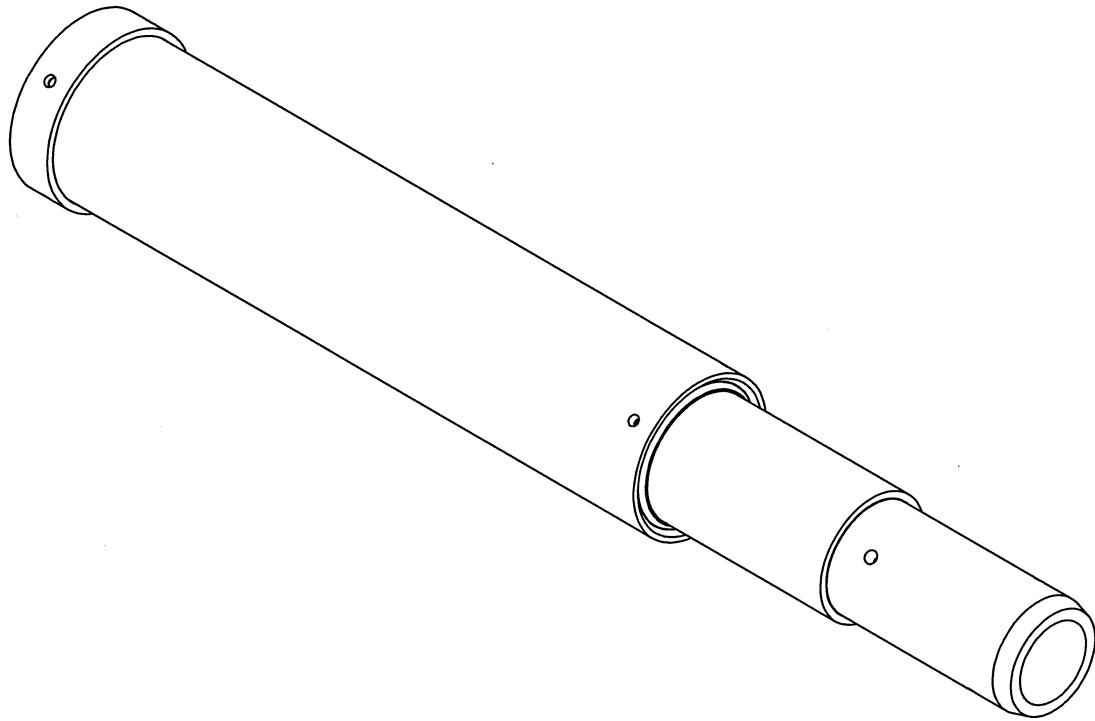
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NOTES:

- 1) MATERIAL: McMaster#9421K65 OR EQUIV. (ROUND BELLOWS WITH CUFF ENDS 1 FT EXTENDED LENGTH X 2-1/2" ID)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 16 OF 27
APPROVED	VM	TITLE	SCALE
DATE 3/8/2019		TOW DOLLY TONGUE ASSY	NTS
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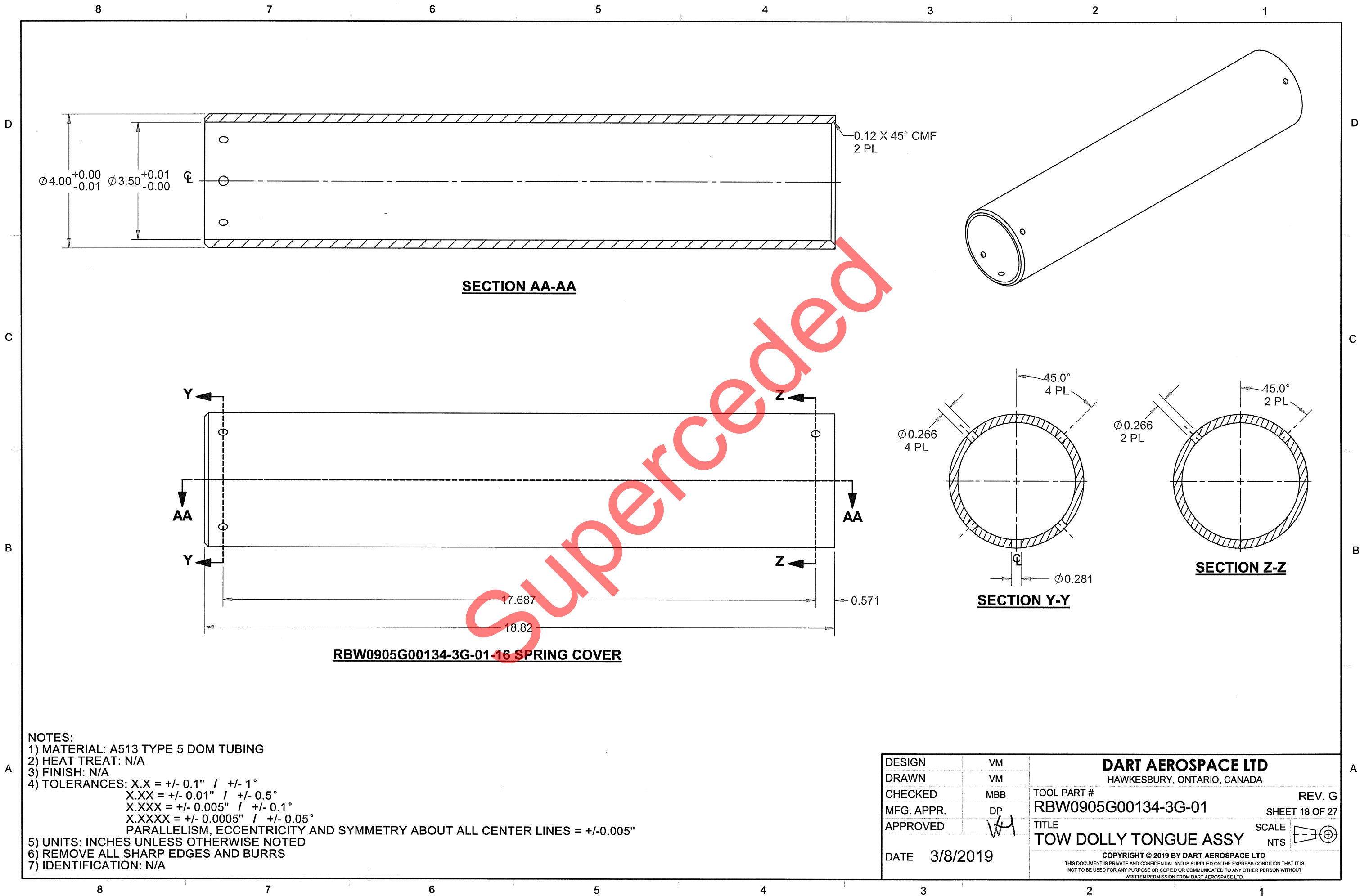
ITEM #	QTY	PART #	PART TITLE
-16	1	RBW0905G00134-3G-01-16	SPRING COVER
-17	1	RBW0905G00134-3G-01-17	TAIL
-18	1	RBW0905G00134-3G-01-18	SPRING END COVER

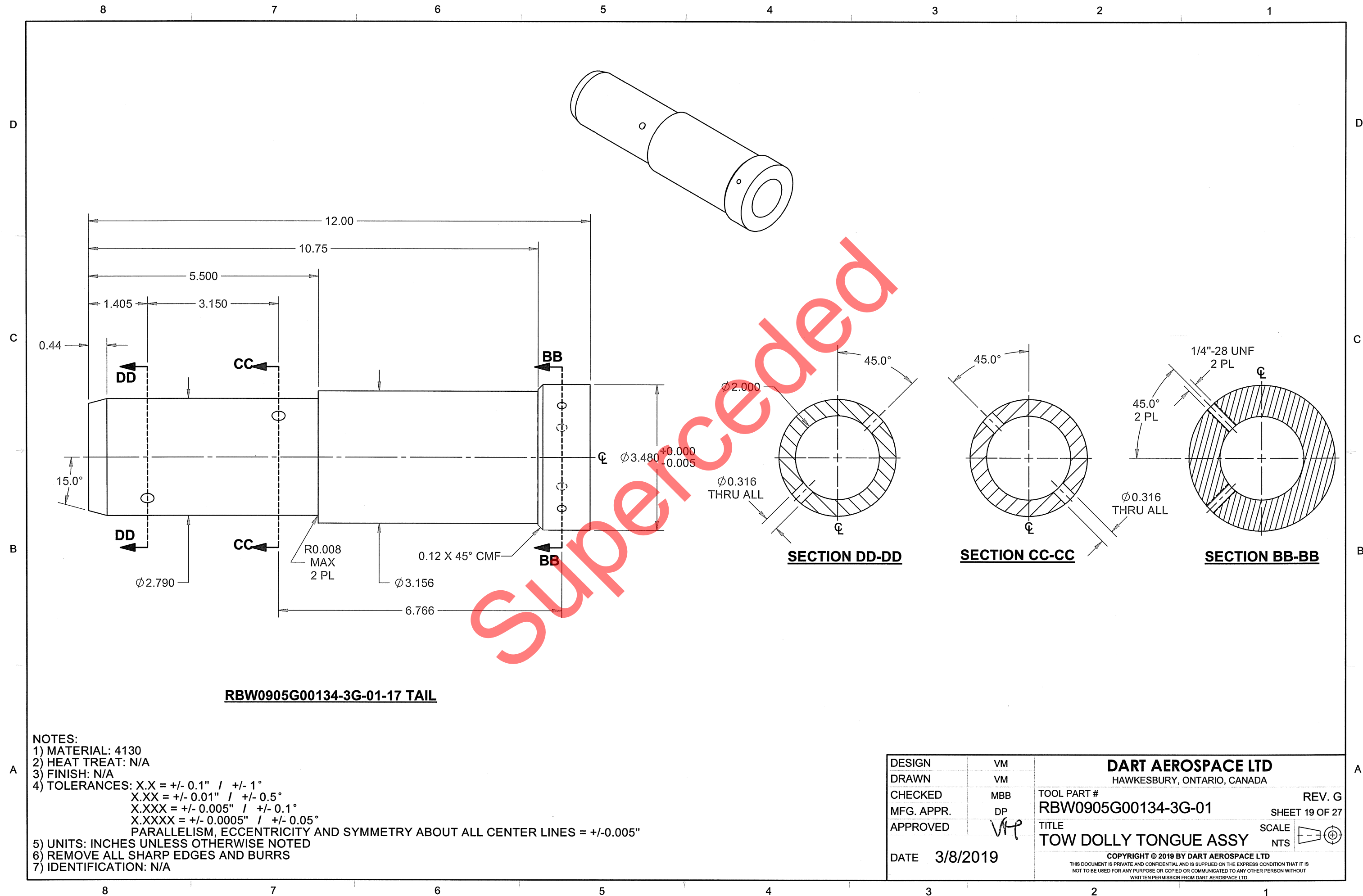


RBW0905G00134-3G-01-15 SPRING COVER ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN HOLES MUST BE ALIGN BEFORE WELDING
8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 17 OF 27
APPROVED	VM	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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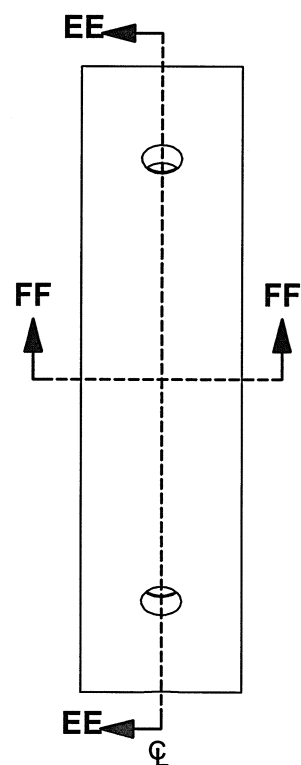


RBW0905G00134-3G-01-17 TAIL

- NOTES:
- 1) MATERIAL: 4130
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 19 OF 27
APPROVED	VM	TITLE	SCALE
DATE 3/8/2019		TOW DOLLY TONGUE ASSY	NTS
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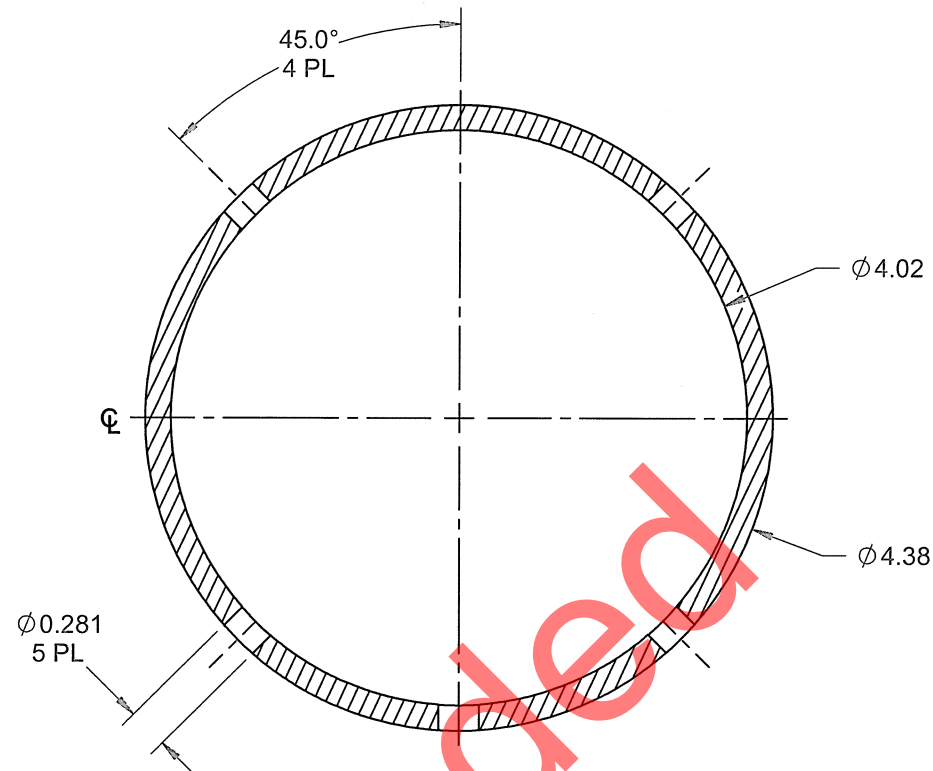
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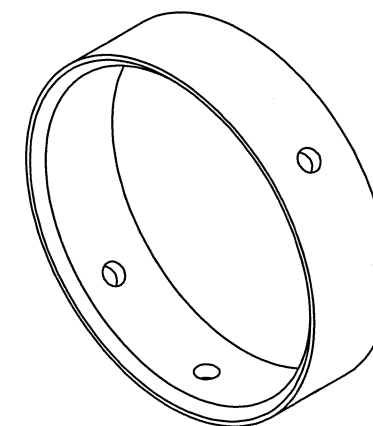
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0.12 X 45° CMF

SECTION FF-FF



SECTION EE-EE

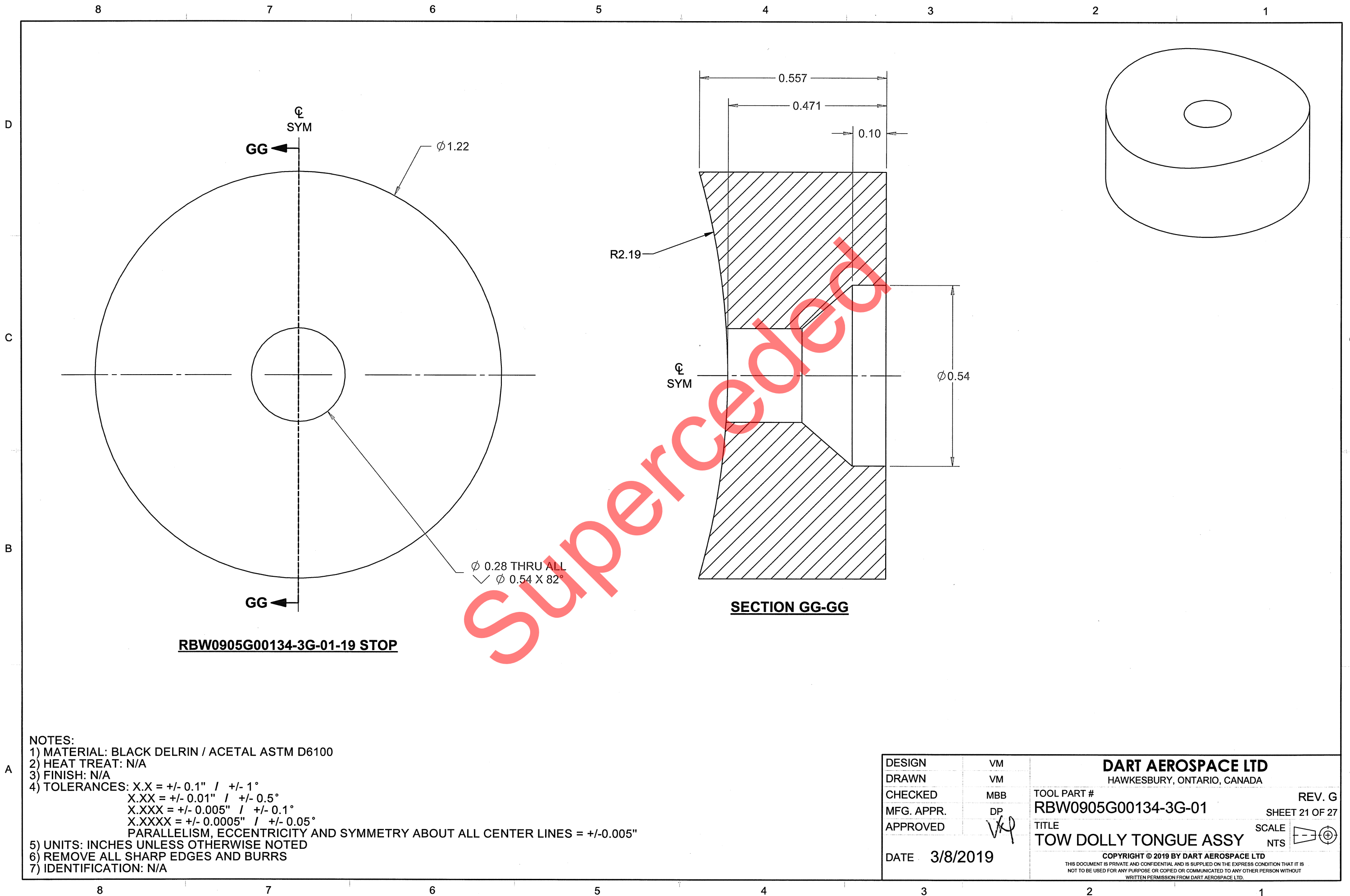


RBW0905G00134-3G-01-18 SPRING END COVER

NOTES:

- 1) MATERIAL: 4130
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 20 OF 27
APPROVED	WJ	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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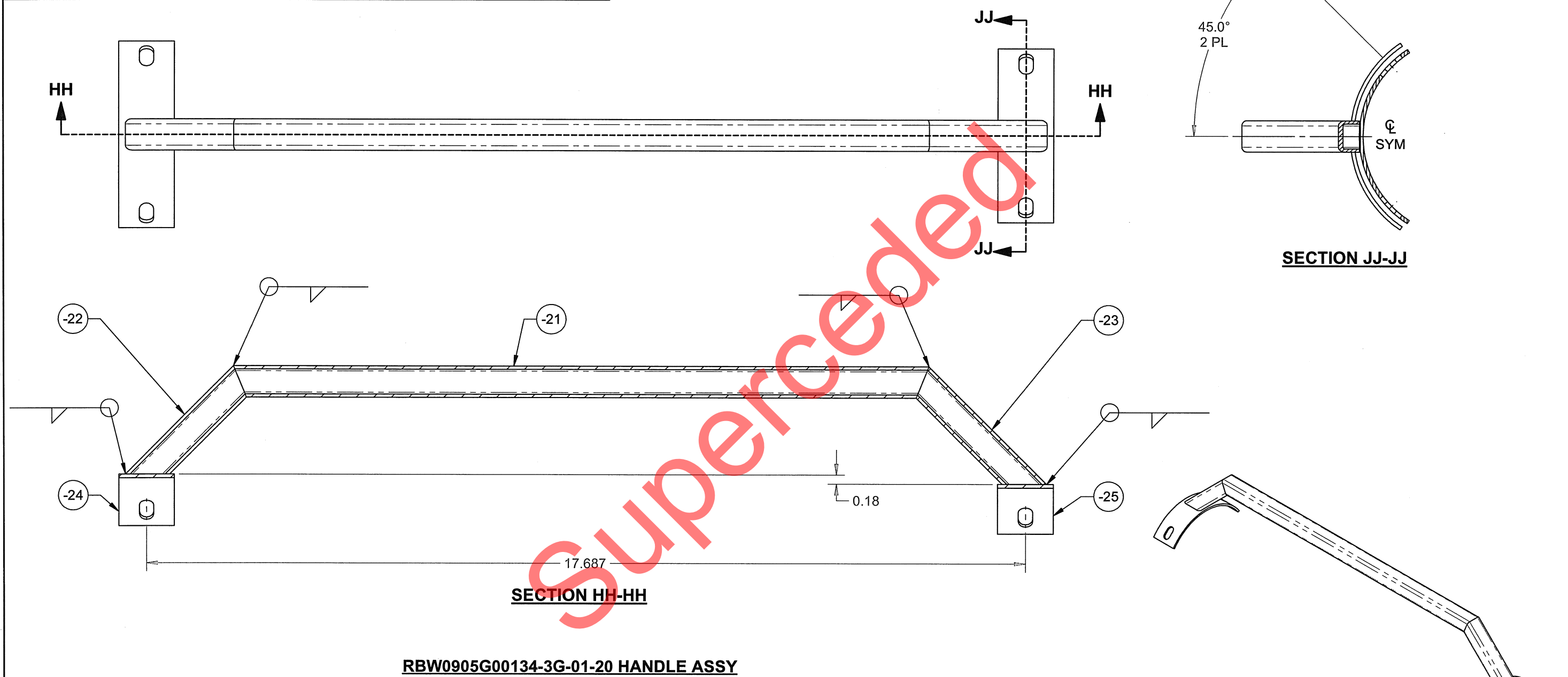


RBW0905G00134-3G-01-19 STOP

NOTES:
1) MATERIAL: BLACK DELRIN / ACETAL ASTM D6100
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 21 OF 27
APPROVED	VK	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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ITEM #	QTY	PART #	PART TITLE
-21	1	RBW0905G00134-3G-01-21	TOP TUBE
-22	1	RBW0905G00134-3G-01-22	FRONT TUBE
-23	1	RBW0905G00134-3G-01-23	REAR TUBE
-24	1	RBW0905G00134-3G-01-24	FRONT MOUNT
-25	1	RBW0905G00134-3G-01-25	REAR MOUNT



NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (AS PLATED) PER ASTM B633 TYPE 1 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 22 OF 27
APPROVED	W	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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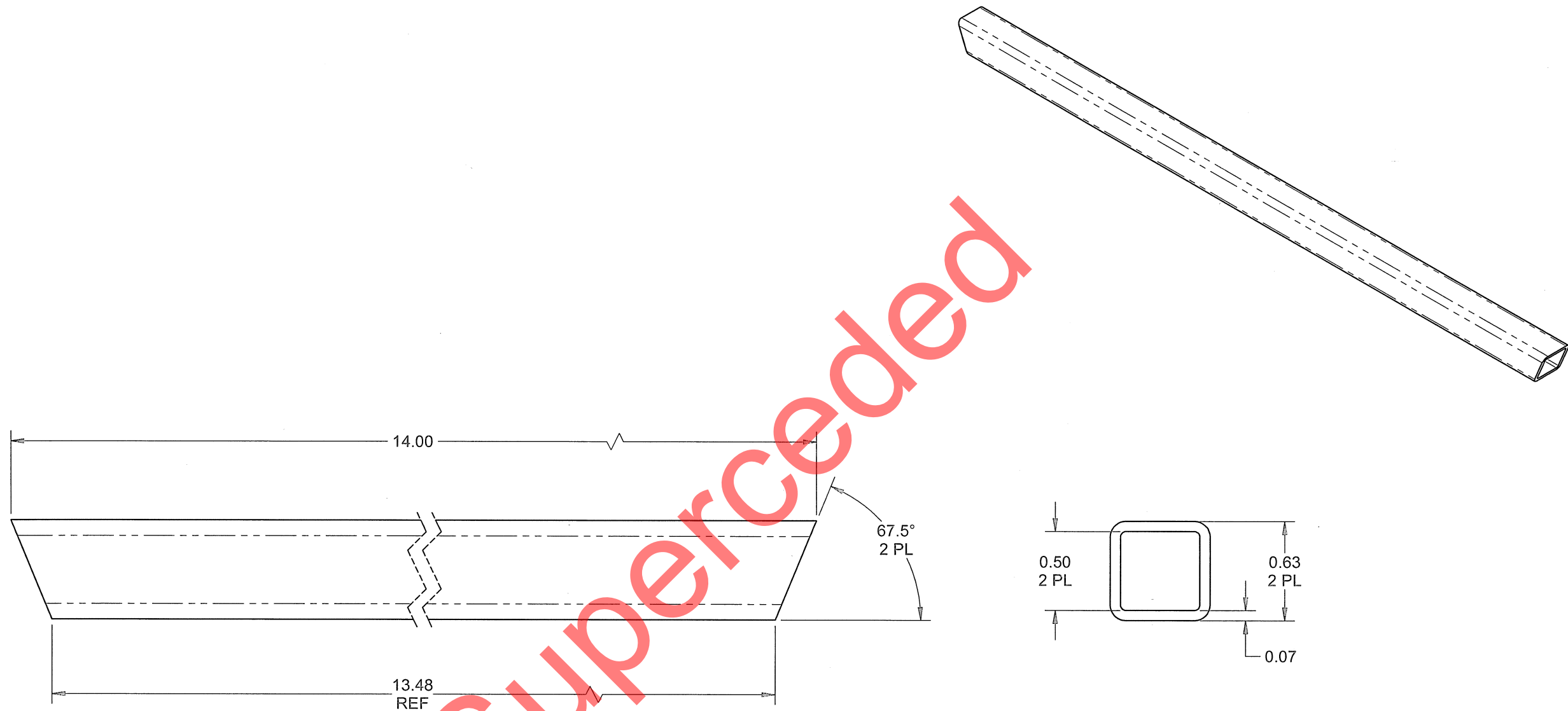
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**RBW0905G00134-3G-01-21 TOP TUBE****NOTES:**

1) MATERIAL: A513 TYPE 5 DOM TUBING

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 23 OF 27
APPROVED	VM	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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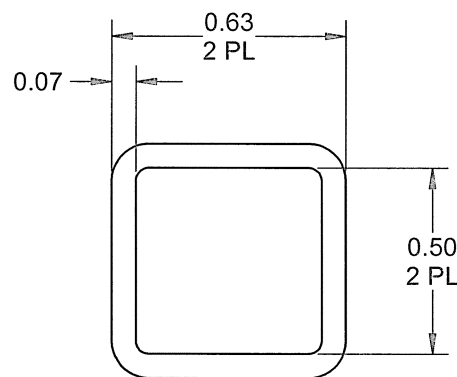
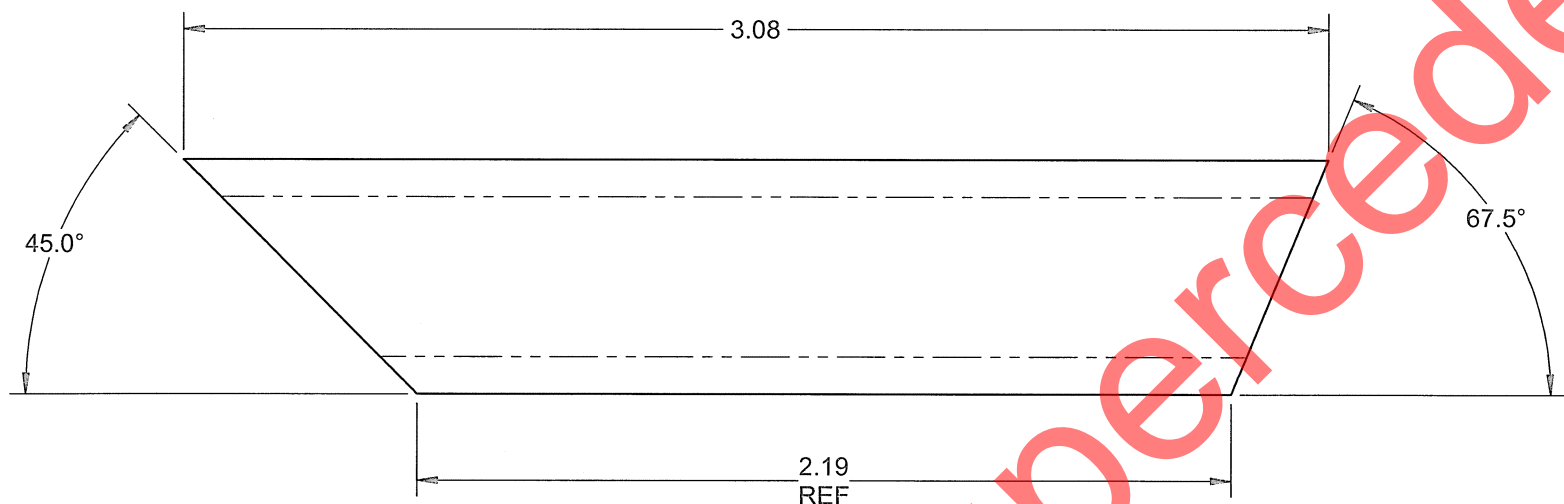
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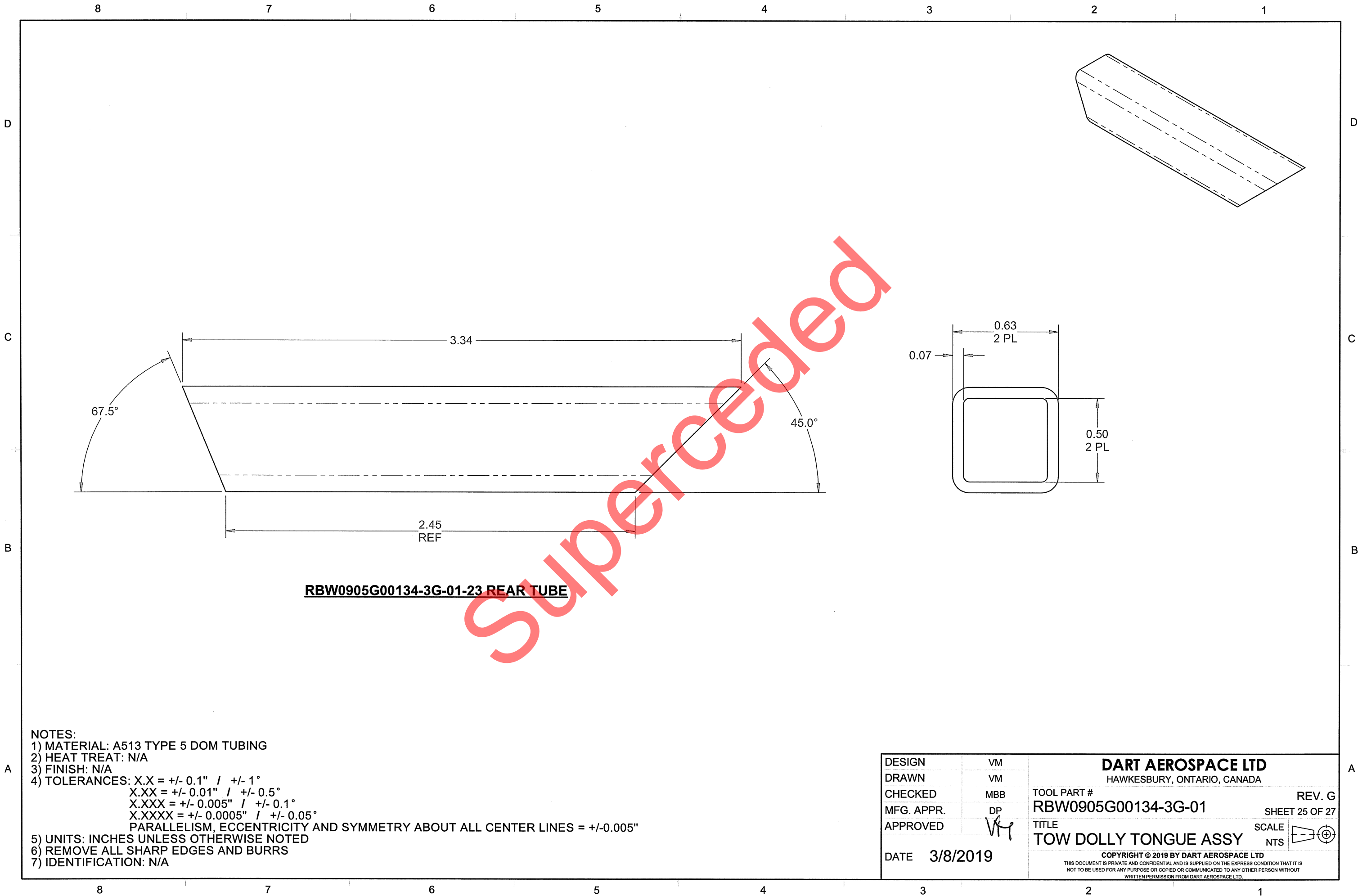
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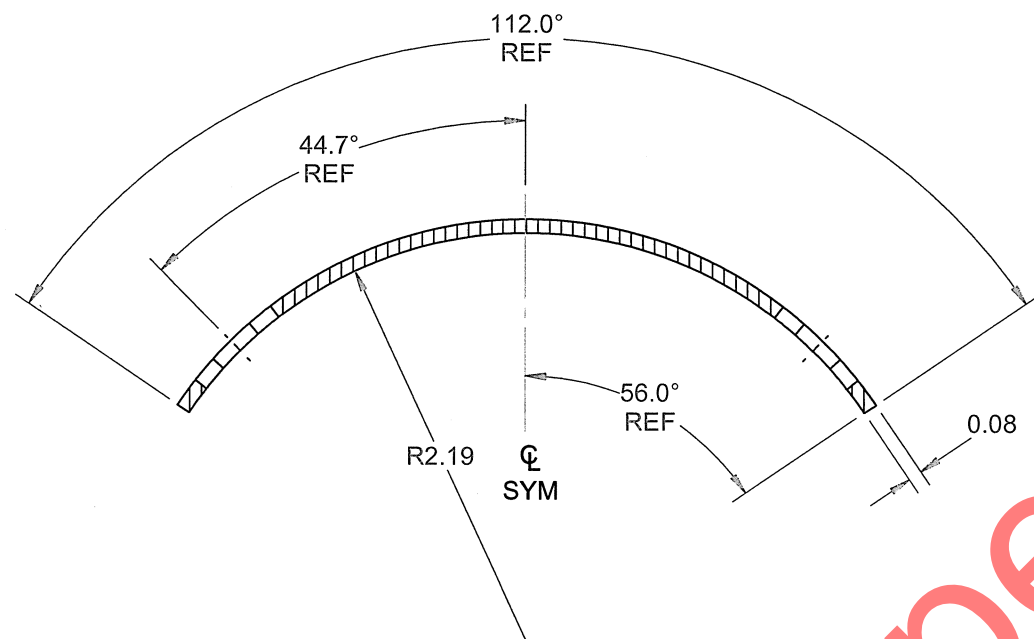
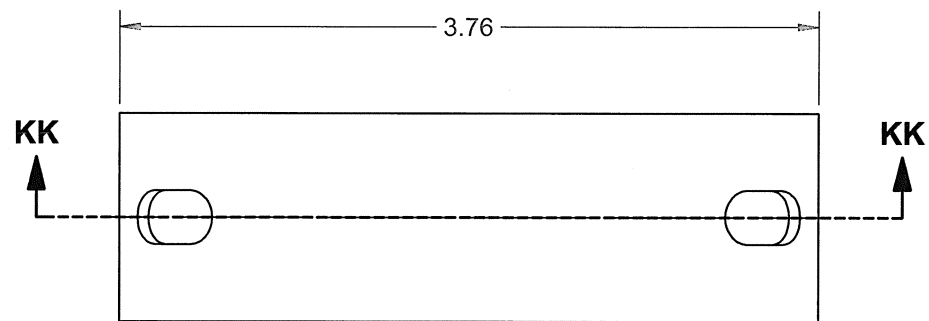


RBW0905G00134-3G-01-22 FRONT TUBE

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

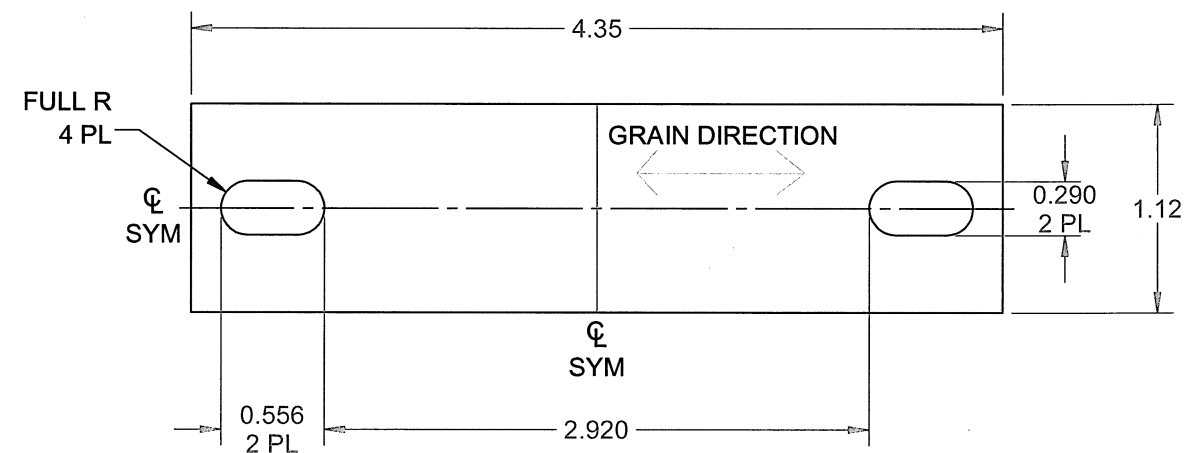
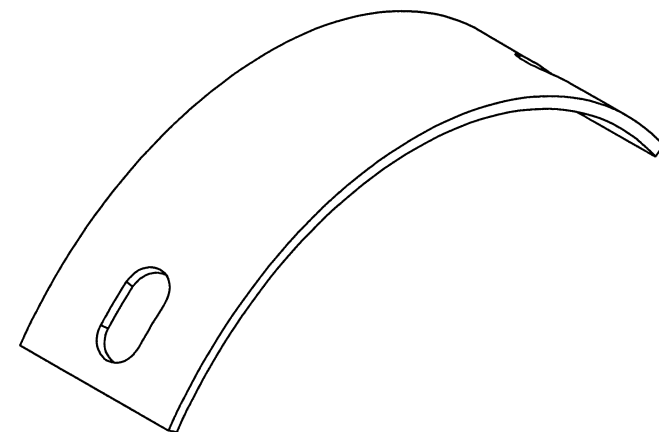
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 24 OF 27
APPROVED	VP	TITLE	SCALE
DATE	3/8/2019	TOW DOLLY TONGUE ASSY	NTS
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SECTION KK-KK

RBW0905G00134-3G-01-24 FRONT MOUNT



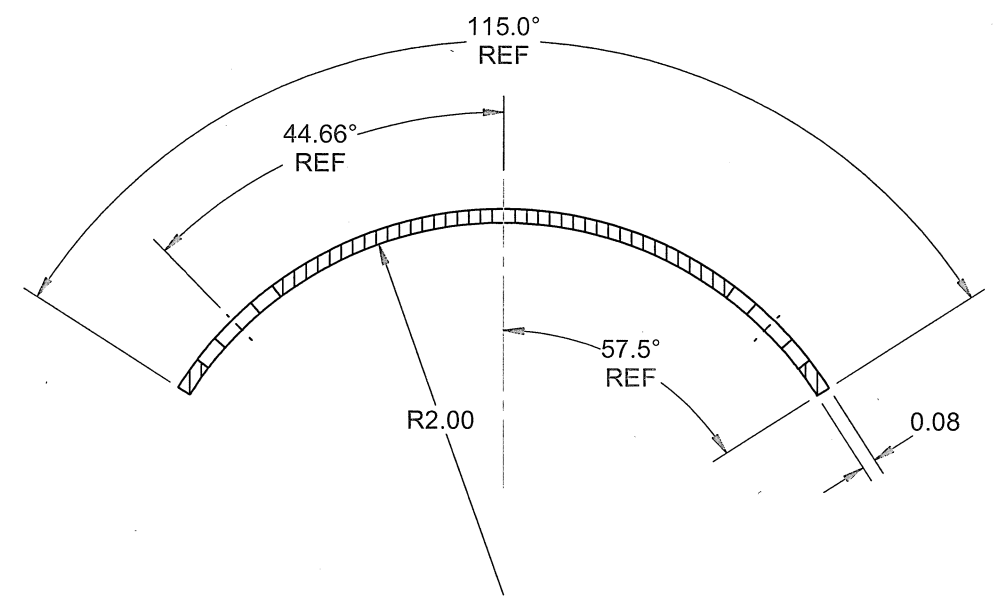
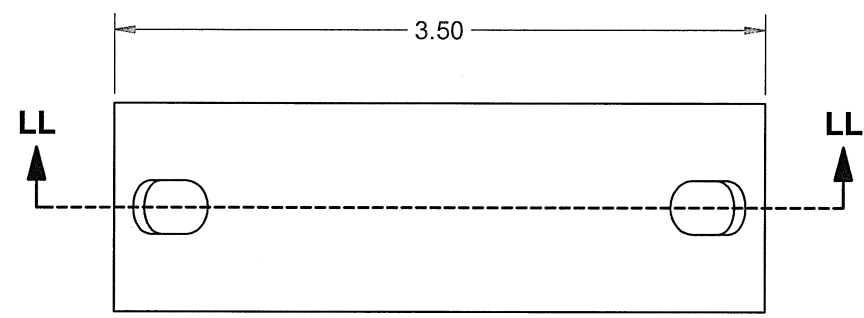
FLAT PATTERN

NOTES:

- 1) MATERIAL: A36/1018/1020/1025 HR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

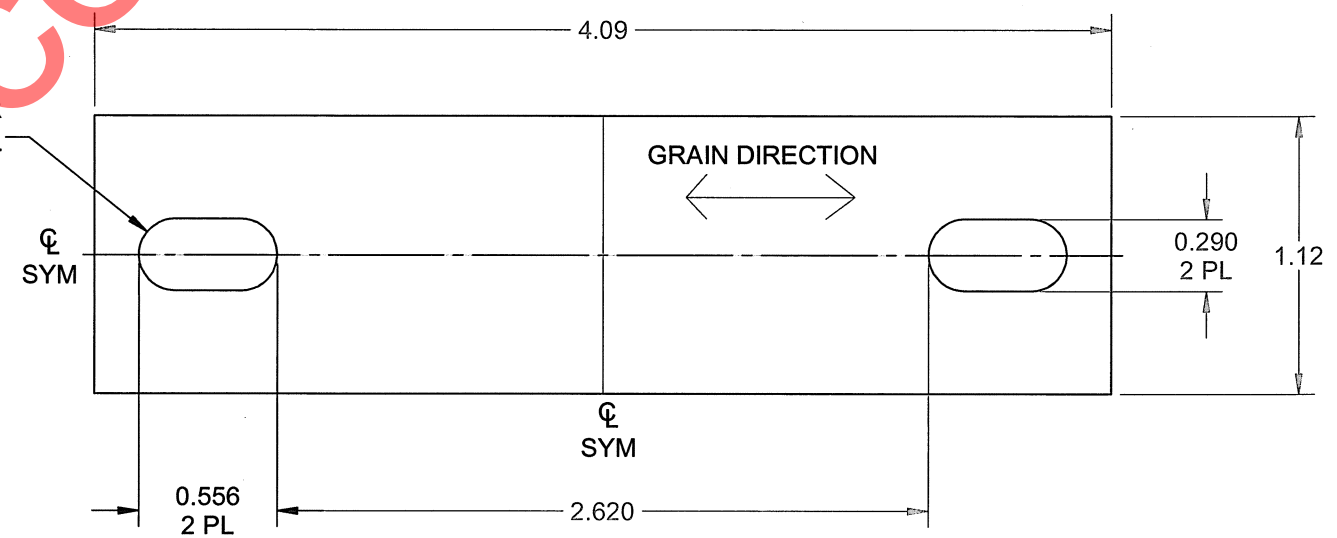
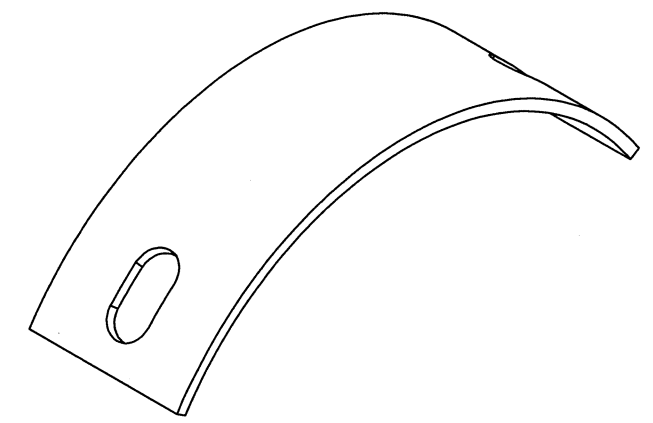
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 26 OF 27
APPROVED	VM	TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
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8 7 6 5 4 3 2 1



SECTION LL-LL

RBW0905G00134-3G-01-25 REAR MOUNT



FLAT PATTERN

- NOTES:
- 1) MATERIAL: A36/1018/1020/1025 HR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. G
MFG. APPR.	DP	RBW0905G00134-3G-01	SHEET 27 OF 27
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		TOW DOLLY TONGUE ASSY	NTS
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